

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-409Cb is a metal-cored wire with addition of fewer ionization element to increase arc stability.
- Higher welding efficiency on thin plate; lower possibility of burn-through, higher deposition rate, better weldability and less sparkle than solid wire.
- It is suitable for AISI 409 the ferritic stainless steel and the similar alloy steels, especially for the automotive exhaust systems and mufflers.

NOTE ON USAGE :

- Use mixed gas with 80%Ar+20%CO₂ and the flow with 15~20 l/min.

WELDING POSITION :



CHEMICAL COMPOSITION (GAS SHIELD: 80%AR+20%CO₂)

C	Mn	Si	P	S	Cr	Nb
0.038	0.78	0.65	0.015	0.006	12.70	0.70

MECHANICAL PROPERTY (GAS SHIELD: 80%AR+20%CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
480(49.0)	16	780 °C×2hr

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	Diameter (mm)	1.2
		F, H
Voltage (Volt)		28-32
Current (Amp)		200-240