

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-410 is a martensitic structure, the weld metal contains 13%Cr.
- The hardness the advantage of oxidation and corrosion resistances at high temp.
- It is suitable for SUS 403, 410, 410S, 420J1 and 420J2 steels.

NOTE ON USAGE :

- Use CO₂ within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.
- Preheat at 200 ~ 400°C before welding, and the PWHT at 730 ~ 760°C afterwards.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO₂)

C	Mn	Si	P	S	Ni	Cr
0.042	0.41	0.45	0.021	0.012	0.21	12.10

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
620(63.7)	22	750°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.6	
	F, H	V, OH	F, H	V, OH
Voltage (Volt)	23-36	22-26	28-36	—
Current (Amp)	130-250	120-160	180-300	—