

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-410NM is a hardfacing flux-cored wire, the weld metal contains 12%Cr-4%Ni-0.5%Mo as a martensitic structure.
- It is suitable for the wear/abrasion and corrosion between metals in any kind of spots such as crane track, printing roller, and the hardfacing maintenance of steel shaft.

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 150°C before welding.

WELDING POSITION :



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

C	Mn	Si	P	S	Ni	Cr	Mo
0.070	0.42	0.38	0.030	0.008	3.80	12.10	0.85

TYPICAL HARDNESS OF WELD METAL : (GAS SHIELD: CO₂)

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	39	41	42

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	-