

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-70C is a 490N/mm² grade metal cored wire.
- Designed for high speed horizontal fillet welding on primed plate (inorganic primer coated) with excellent pit resistance.
- It performs good penetration, slag removal, good X-Ray soundness and excellent impact value.
- It is widely used for flat and horizontal fillet welding in ship building, bridges, vehicle, machinery and structural fabrication etc.

NOTE ON USAGE :

- Use CO₂ shielding gas with flow rate 15~25 l/min. Once use for Mix shielding gas with 75~80%Ar + 20~25%CO₂ would be taken excellent management.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : 100% CO₂)

C	Mn	Si	P	S
0.042	1.30	0.42	0.010	0.005

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 100% CO₂)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -20 °C J(Kgf-m)
515(52.6)	570(58.1)	27	100(10.2)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.4		1.6	
	F	Vertical-up	F	Vertical-up	F	Vertical-up
Voltage(Volt)	22-34	22-36	22-38	21-38	24-40	22-40
Current (Amp)	150-300	180-300	180-350	200-350	200-400	270-400
Stickout(m/m)	15-25		20-30		20-30	
Flow Rate(l/min)	15-25		20-25		20-25	