

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-71M is a 490N/mm² grade metal cored wire.
- With good welding management, very little fume, less spatter and nice bead appearance, good X-Ray soundness and excellent toughness.
- It is widely used for ship building, storage tanks, machinery, bridges, steel structure and piping 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 : 80%Ar + 20%CO₂)

C	Mn	Si	P	S
0.051	1.43	0.45	0.010	0.006

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 80%Ar + 20%CO₂)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -40 °C J(Kgf-m)
480(49.0)	540(55.1)	26	77

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	1.2	1.4	1.6
Parameters	F	F	F
Voltage(Volt)	24-33	26-35	28-38
Current (Amp)	150-300	180-350	200-400
Stickout(m/m)	10-15	15-20	15-30
Flow Rate(l/min)	15-25	15-25	15-25