

ELECTROGAS ARC WELDING FOR 490N/mm² HIGH TENSILE STEEL (EGW)

DESCRIPTION & APPLICATIONS :

- SFC-721 is a self-shielded flux cored wire designed for vertical up, single pass welding with high deposition rate.
- Suitable for mild steel, high tensile steel, base metal thickness range 19-100mm. Such as steel structure, boxes,, heavy shop fabrication welding.

NOTE ON USAGE :

- Pre-heat the workpiece and welding zone.
- Consumable guide tube material chemistry close to deposit metal is recommended. (ref. AISI Grades 1008 to 1020)

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Mo
0.08	1.32	0.26	0.014	0.006	0.12

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
440(44.9)	580(59.2)	25	56(5.7)

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Diameter (mm)	3.0			
Parameters				
Thickness (mm)	19	25	38	50
WFS (cm/min)	510	580	750	890
Voltage (Volt)	34-37	38-41	41-43	43-45