

FLUX CORED WIRES FOR HEAT RESISTANT LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- The weld metal of SFC-81A1 is 0.5% molybdenum.
- Suitable for pressure vessel, pressure pipe, and boiler.

NOTE ON USAGE :

- Use DC (+) polarity. CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min.
- Proper preheat at 100 ~ 200°C and PWHT at 620 ~ 680°C.

WELDING POSITION :



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

C	Mn	Si	P	S	Mo
0.040	1.05	0.46	0.010	0.006	0.61

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
596(60.8)	643(65.6)	24	620°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.4		1.6	
	F/H	V/OH	F/H	V/OH	F/H	V/OH
Voltage (Volt)	30-36	25-28	32-40	26-30	34-42	26-30
Current (Amp)	250-330	150-220	270-360	170-220	300-400	170-220