

FLUX CORED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SFC-81K2 is a 550N/mm² grade high tensile strength steel metal core wire.
- Suitable for ship body, storage tank, engineering machinery, bridge structure, steel structure, and pipe.

NOTE ON USAGE :

- Use CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min. 80%Ar+20%CO₂ can also be used to get better weldability.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (100%CO₂, MIX 80%Ar+20%CO₂)

C	Mn	Si	P	S	Ni	Gas
0.006	0.75	0.36	0.006	0.005	0.40	CO ₂
0.007	1.00	0.50	0.006	0.006	0.38	MIX

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (100%CO₂, MIX 80%Ar+20%CO₂)

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -60 °C J(Kgf-m)	Gas
480(49.0)	590(60.2)	30	55(5.6)	CO ₂
585(59.7)	621(63.4)	27	67(6.8)	MIX

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)			23-34	18-23	24-36	20-23	26-38	20-23
Current (Amp)			150-300	80-150	180-350	100-150	200-400	100-150
Stickout (m/m)			10-15		15-20		15-30	
Gas flow (l/min)			15-25		15-25		20-25	