SFC-81Ni1

AWS A5.29 E81T1-Ni1C/M
EN ISO 17632-A T46 3 1Ni P C1/M21 1
GB T17493 E551T1-Ni1

FLUX CORED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SFC-81Ni1 is a low alloy flux core wire designed for 550N/mm^2 grade steel. The weld metal of is SFC-81Ni1 1%Ni.
- Suitable for low temperature container, ocean construction, storage tank, pipe, and welding of high tensile strength structure.

NOTE ON USAGE :

- Use DC (+) polarity. CO_2 gas (min. 99.8%) G.F.R: 15~25 l/min.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO_2)

C	Mn	Si	P	S	Ni
0.048	1.26	0.45	0.010	0.006	0.95

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO_2)

YIELD POINT N/mm^2(Kgf/mm^2)	TENSILE STRENGTH N/mm^2(Kgf/mm^2)	ELONGATION RATE %	IMPACT VALUES -30 °C J(Kgf-m)
534(54.5)	618(63.1)	28	85(8.7)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

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