

FLUX CORED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SFC-81Ni2 is a low alloy flux core wire designed for 550N/mm² grade steel. The weld metal of is SFC-81Ni1 2%Ni.
- Suitable for low temperature container, ocean construction, storage tank, pipe, and welding of high tensile strength structure.

NOTE ON USAGE :

- Use DC (+) polarity. CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min.

WELDING POSITION :



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

C	Mn	Si	P	S	Ni
0.052	1.30	0.35	0.009	0.006	2.00

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 %	IMPACT VALUES -40 °C/- 60 °C J(Kgf-m)
560(57.1)	631(64.4)	27	100(10.2)/55(5.6)

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	32-34	26-30	34-42	26-30
Current (Amp)	250-330	150-220	270-360	170-220	300-400	170-220