

FLUX CORED WIRES FOR ATMOSPHERIC CORRSION RESISTANT LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

● SFC-81W2 is a 550N/mm² grade atmospheric corrosion resistant low alloy steel metal core wire.

● Suitable for ASTM A242, A588, bridge, and building.

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	Cr	Cu
0.04	1.00	0.40	0.010	0.005	0.48	0.60	0.41

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 -30 °C J(Kgf-m)
570(58.2)	630(64.3)	25	53(5.4)

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