

FLUX CORED WIRES FOR HEAT RESISTANT LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- The weld metal of SFC-91B3 is 2.25%Cr-1%Mo.
- Suitable for chemical plant, oil refinery equipment, high temperature high pressure pipe.

NOTE ON USAGE :

- Use DC (+) polarity. CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min.
- Proper preheat at 200 ~ 350°C and PWHT at 680 ~ 730°C.

WELDING POSITION :



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

C	Mn	Si	P	S	Cr	Mo
0.055	1.10	0.35	0.012	0.06	2.45	1.11

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
650(66.3)	720(73.5)	20	690 °C x 1hr

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