

FLUX CORED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SFC-91Ni2 is a 620N/mm² grade high tensile strength steel. The weld metal of is SFC-91Ni2 2.2%Ni.
- Suitable for low temperature container, ocean construction, storage tank, and pipe.

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
0.035	1.35	0.52	0.009	0.006	2.20

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/- 50 °C J(Kgf-m)
600(61.2)	680(69.4)	24	58(5.9)/49(5.0)

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