SF-60 x SWE-60G

ELECTROSLAG WELDING WIRE AND FLUX FOR \( \geq 550 \text{N/mm}^2 \) HIGH TENSILE STEEL

DESCRIPTION:
SF-60 is a fused type flux for electrodeslag welding of 550N/mm\(^2\) grade tensile steel. The combination of SF-60 and low-alloyed wire such as SWE-60G will get a deposit with refined microstructure, increase the toughness and provide excellent mechanical properties.

APPLICATIONS:
It is used for the joint welding of 550N/mm\(^2\) high tensile steel and suitable for ship building, bridges, steel structures, etc, especially good for box welding.

NOTE ON USAGE:
1. Keep the base metal gap below 0.5mm, and use tack welding outside the welding parts.
2. Clean up the weld parts free from oil, moisture, and keep it as design before welding.
3. E.S.O. to be maintained at 30~40mm

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt\%):
Weld Metal Analysis:
Carbon (C) \hspace{1cm} 0.12
Manganese (Mn) \hspace{1cm} 1.52
Silicon (Si) \hspace{1cm} 0.14
Sulphur (S) \hspace{1cm} 0.08
Other \hspace{1cm} little

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
YP N/mm\(^2\) \hspace{1cm} 545
TS N/mm\(^2\) \hspace{1cm} 637
EL\% \hspace{1cm} 27

TYPICAL IMPACT VALUES (with SW-M12K Wire):
IV -30°C J \hspace{1cm} 43

APPROVALS:
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