DESCRIPTION:
SFC-04 is a self-shielded flux cored wire designed for on site fabrications which welder could use it outdoor at the applications with longer stick-out than normal fcaw if wind is not high. Excellent performance in desulfuration reduces porosity effectivel.

APPLICATIONS:
It is designed flat, horizontal and downhill positions welding and suitable for steel structural constructions.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Keep the welding parts clean, out of moisture before welding.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.22
Manganese (Mn) 0.36
Silicon (Si) 0.35
Phosphorus (P) 0.023
Sulphur (S) 0.012
Aluminum (Al) 1.23

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 458
TS N/mm² 575
EL% 25

APPROVALS:
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SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>2.0mm</th>
<th>2.4mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>25 ~ 35</td>
<td>25 ~ 39</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>200 ~ 350</td>
<td>200 ~ 400</td>
<td></td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>30 ~ 50</td>
<td>30 ~ 50</td>
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