DESCRIPTION:
SFC-07 is a self-shielded flux cored wire designed for on site fabrications which welder could use it outdoor for high deposition welding. Excellent performance in desulfuration reduces cracking in welding thick plates.

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

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) 0.23
Manganese (Mn) 0.38
Silicon (Si) 0.2
Phosphorus (P) 0.018
Sulphur (S) 0.015
Aluminum (Al) 1.42

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
YP N/mm2 486
TS N/mm2 582
EL% 26

APPROVALS:
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SUGGESTED WELDING PARAMETERS (DC <-->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.6mm</th>
<th>2.0mm</th>
<th>2.4mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>22 ~ 27</td>
<td>23 ~ 30</td>
<td>27 ~ 32</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>250 ~ 450</td>
<td>250 ~ 550</td>
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<tr>
<td>Stickout (mm)</td>
<td>30 ~ 40</td>
<td>30 ~ 40</td>
<td>35 ~ 50</td>
<td></td>
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</table>