DESCRIPTION:
SFC-101 is a gas-shielded high tensile strength flux cored wire designed for high tensile steel carries 690N/mm², suitable for all-positional welding.

APPLICATIONS:
It is designed for petro chemical industry, oil refinery components, pipes.

NOTE ON USAGE:
1. Use DC (+) polarity. CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min
2. Keep the welding parts clean, out of moisture before welding.
3. Pre-heat the workpiece at temp. 220~350°C
4. Proper protection from wind during welding, reduce the H₂ and N pick up.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO₂)
Weld Metal Analysis:
Carbon (C) 0.06
Manganese (Mn) 1.21
Silicon (Si) 0.45
Phosphorus (P) 0.021
Sulphur (S) 0.012
Nickel (Ni) 0.63
Chromium (Cr) 0.35
Molybdenum (Mo) 0.41

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO₂)
YP N/mm² 660
TS N/mm² 721
EL% 22

APPROVALS:

SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
<th>1.6mm</th>
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</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>25 ~ 35</td>
<td>30 ~ 40</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 330</td>
<td>300 ~ 400</td>
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