DESCRIPTION:
SFC-110 is a gas-shielded high tensile strength flux cored wire designed for high tensile steel carries 780N/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) 0.047
Manganese (Mn) 1.42
Silicon (Si) 0.32
Phosphorus (P) 0.014
Sulphur (S) 0.009
Nickel (Ni) 2.76
Molybdenum (Mo) 0.47

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 658
TS N/mm² 801
EL% 21

TYPICAL IMPACT VALUES:
IV -40°C J 42

APPROVALS:
ABS

SUGGESTED WELDING PARAMETERS (DC <+>):

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