DESCRIPTION:
SFC-120 is a 830N/mm2 high tensile strength flux cored wire.

APPLICATIONS:
It suits for petro chemical industry, oil refining components, machinery and bridges.

NOTE ON USAGE:
1. Use DC(+) polarity.
2. Shielding gas: 99.8% CO2; Flow rate: 15-25 l/min
3. Clean up the base metal to be free from contamination.
5. Proper wind-proof while welding will minimize Nitrogen & Hydrogen content in the deposit metal and avoid tensile strength reduction and blow hole occurs.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.45
Manganese (Mn) 1.77
Silicon (Si) 0.26
Molybdenum (Mo) 0.55
Nickel (Ni) 2.41
Sulphur (S) 0.009
Phosphorus (P) 0.013

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm2 664
TS N/mm2 856
EL% 21
IV J (-30°C) 50

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></td>
<td>25 ~ 35</td>
<td>30 ~ 38</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>250 ~ 330</td>
<td>300 ~ 430</td>
</tr>
</tbody>
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