SFC-18

FLUX CORED WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION:
SFC-18 is a self-shielded flux cored wire. Superior crack resistance, slag detachability, high deposition rate, and good penetration are the characteristics of design, fluidity of deposit metal enable the welding for all-positions.

APPLICATIONS:
It is suitable for structural welding outdoors, such as steel structures, chimney, pipes, etc.

NOTE ON USAGE:
1. Use DC (-) polarity.
2. Use self-shield welding devices for welding.
3. Clean the surface of base metal to prevent contamination.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.15
Manganese (Mn) 0.72
Silicon (Si) 0.13
Phosphorus (P) 0.018
Sulphur (S) 0.010
Aluminum (Al) 0.68

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 442
TS N/mm² 553
EL% 24
IV J (-30°C) 47

APPROVALS:
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SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>2.0mm</th>
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<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>18 ~ 25</td>
<td></td>
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<tr>
<td>Current (Amp)</td>
<td>150 ~ 350</td>
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<tr>
<td>E.S.O.(mm)</td>
<td>30 ~ 40</td>
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