DESCRIPTION:
SFC-307 is a flux cored tubular wire for all-positional welding using pure CO2 shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple etc. Strong and tough austenitic weld metal composition for dissimilar joints and buffer layers.

APPLICATIONS:
Designed for dissimilar combinations of C-Mn, stainless, hardenable, wear-resistant and armour steels. Also suitable for 13% Mn steel.

NOTE ON USAGE:
1. Clean up the base metal from contamination.
2. Use DC (+) polarity.
3. Use CO2 shielding gas, 99.8% CO2 gas with flow rate 20-25 l/min.
4. Use proper protection for getting good toughness and avoid blow hole, lower the hydrogen and nitrogen content in the deposit metal.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):(Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.053
Chromium (Cr) 19.50
Nickel (Ni) 9.52
Manganese (Mn) 3.62
Molybdeum (Mo) 0.80
Silicon (Si) 0.68
Phosphorus (P) 0.028
Sulphur (S) 0.008

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
TS N/mm² 589
EL% 40

APPROVALS:

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>Welding Position</td>
<td>F, HF</td>
<td>V-UP, OH</td>
<td>F, HF</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>23 ~ 33</td>
<td>25 ~ 30</td>
<td>27 ~ 32</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>130 ~ 220</td>
<td>120 ~ 200</td>
<td>200 ~ 300</td>
</tr>
</tbody>
</table>