DESCRIPTION:
SFC-309MoL is a rutile flux cored tubular wire for all-positional welding using pure CO2 shielding gas. It performs with smooth arc transfer, low spatter level, fine ripple, fast freezing slag, easy control of weld pool, good heat and corrosion resistance.

APPLICATIONS:
Suitable for welding 22%Cr-12%Ni-2.5%Mo stainless steels and dissimilar metals such as ferritic and austenitic stainless steels, as well as for joining ferritic martensitic steels. It is also used for buffer layers of clad steels.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.030
Manganese (Mn) 0.89
Silicon (Si) 0.71
Phosphorus (P) 0.021
Sulphur (S) 0.012
Nickel (Ni) 13.60
Chromium (Cr) 23.4
Molybdenum (Mo) 2.43

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
TS N/mm² 585
EL% 37

APPROVALS:
ABS, CE

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>Welding Position</td>
<td>1.0 F, HF</td>
<td>1.0 F, HF</td>
<td>1.0 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>
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