DESCRIPTION:
SFC-312M is a modified flux cored wire with high ferrite content in weld metal. Because of the chemical adjustment, it has superior crack and corrosion resistance than SFC-312. Stable arc, less spatter and good slag detachability make it suitable for all-positional welding.

APPLICATIONS:
It is suitable for stainless to alloy steel, and to carbon steel joints, provides superior crack resistance than SFC-312. High deposit content of Ferrite than 309, suitable for overlay applied onto carbon steel and alloy steels, however, not recommended for heat treatments.

NOTE ON USAGE:
1. Clean up the base metal from contamination.
2. Use DC(+) for welding.
3. Use CO2 shielding gas, 99.8% CO2 gas with flow rate 20-25 l/min. to avoid N content increasing, which decreases the toughness.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO2)
Weld Metal Analysis :
Carbon (C) 0.024
Chromium (Cr) 26.40
Nickel (Ni) 8.30
Manganese (Mn) 0.81
Silicon (Si) 0.55
Phosphorus (P) 0.025
Sulphur (S) 0.003
Others 1.6

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
TS N/mm2 730
EL% 23

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></td>
<td>F, HF</td>
<td>F, HF</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td></td>
<td>23 ~ 33</td>
<td>27 ~ 32</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>130 ~ 220</td>
<td>200 ~ 300</td>
</tr>
</tbody>
</table>