DESCRIPTION:
SFC-316H is a flux cored tubular wire for all positional welding using pure CO2 or Argon CO2 mixed shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple and good intergranular corrosion resistance.

APPLICATIONS:
Suitable for welding 18%Cr-12%Ni-2% Mo stainless steels. Typical applications include corrosion resistance overlay, joining of type 316, 316L, CF-8M, and CF-3M stainless steels pipe and tube in chemical, oil and gas refineries.

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) 18.23
Nickel (Ni) 11.71
Molybdenum (Mo) 2.53
Manganese (Mn) 1.42
Silicon (Si) 0.51
Phosphorus (P) 0.02
Sulphur (S) 0.005

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
TS N/mm2 581
EL% 38

APPROVALS:
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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></td>
<td></td>
<td>F, HF</td>
<td>V-UP. OH</td>
</tr>
<tr>
<td>Welding Position</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>23 ~ 33</td>
<td>25 ~ 30</td>
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<tr>
<td>Current (Amp)</td>
<td>130 ~ 220</td>
<td>120 ~ 200</td>
<td>200 ~ 300</td>
</tr>
</tbody>
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127