DESCRIPTION:
SFC-317L is a rutile 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 19%Cr-12%Ni-3%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. 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) 0.85
Silicon (Si) 0.58
Phosphorus (P) 0.021
Sulphur (S) 0.014
Nickel (Ni) 13.11
Chromium (Cr) 18.94
Molybdenum (Mo) 3.61

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
TS N/mm² 580
EL% 35

TYPICAL IMPACT VALUES:
IV 0°C J 58

APPROVALS:
ABS

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>1.2mm</th>
<th>1.6mm</th>
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</thead>
<tbody>
<tr>
<td>Diameter (mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Welding Position</td>
<td>F, HF</td>
<td>V-UP, OH</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>23 ~ 33</td>
<td>25 ~ 30</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>130 ~ 220</td>
<td>120 ~ 200</td>
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</tbody>
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