DESCRIPTION:
SFC-318 is an austenitic flux cored tubular wire with weld deposit of 18% Cr-12% Ni-2% Mo-Ti(Nb)
Good corrosion resistance against sulfuric acid, a sort of non-oxidizing acid and the Nb content
gives good intergranular corrosion resistance.

APPLICATIONS:
Suitable for welding of AISI 316Ti and SUS316Ti.

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 decrease the toughness.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.03
Chromium (Cr) 18.53
Nickel (Ni) 12.12
Molybdenum (Mo) 2.58
Manganese (Mn) 1.14
Niobium (Nb) 0.49
Silicon (Si) 0.60
Phosphorus (P) 0.023
Sulphur (S) 0.005

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
TS N/mm² 570
EL% 38
IV -60°C J 55

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></td>
<td></td>
<td>F_HF</td>
<td>V-UP_OH</td>
</tr>
<tr>
<td>Welding Position</td>
<td></td>
<td></td>
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<tr>
<td>Voltage (Volt)</td>
<td></td>
<td>23 ~ 33</td>
<td>25 ~ 30</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>130 ~ 220</td>
<td>120 ~ 200</td>
</tr>
</tbody>
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