DESCRIPTION:
SFC-347H is a rutile flux cored tubular wire with deposit metal 19%Cr-9%Ni-Ti(Nb), providing good intergranular corrosion resistance with good tensile strength at high working temperature. Can be welded without PWHT, suitable for the corrosion resistance container welding.

APPLICATIONS:
Designed for welding stabilized stainless steels such as type 347 and 321, resistance overlay, joining of common austenitic stainless steel types 301, 302, 304, 304L and CF-8.

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.
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) 19.78
Nickel (Ni) 10.32
Manganese (Mn) 1.21
Niobium (Nb) 0.44
Silicon (Si) 0.42
Phosphorus (P) 0.023
Sulphur (S) 0.008

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
TS N/mm2 593
EL% 42
IV 0℃ J 48

APPROVALS:
-

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>F. HF</td>
<td>V-UP. OH</td>
<td>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>
</tbody>
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