FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION:
SFC-409Cb is a metal cored flux cored wire with some electrolytic dissociation elements which will enhance the arc stability. High efficiency at fine plate welding and superior weldability and low spatter.

APPLICATIONS:
It is designed and suitable for Ferrite stainless steel AISI409 or similar alloy steel, especially good at exhaust pipe system welding.

NOTE ON USAGE:
1. DC (+); 80% Ar + 20% CO2; G.F.R: 15-20 l/min
2. Use stainless steel wire brush for cleaning of slags

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
(Shielding Gas: 80%Ar + 20%CO2)
Carbon (C) 0.038
Manganese (Mn) 0.450
Silicon (Si) 0.40
Phosphorus (P) 0.015
Sulphur (S) 0.012
Chromium (Cr) 11.20
Niobium (Nb) 0.52

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 80%Ar + 20%CO2)
TS N/mm² 480
EL % 23

APPROVALS:
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SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
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<tbody>
<tr>
<td>Welding Position</td>
<td>F, HF</td>
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<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 32</td>
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<tr>
<td>Current (Amp)</td>
<td>200 ~ 240</td>
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