DESCRIPTION:
SFC-410, which contains 12% chromium, is a flux cored wire for using pure CO2 shielding gas in all position welding. The weld deposit is air hardening and is normally heat-treated after welding.

APPLICATIONS:
SFC-410 is utilized to weld straight 410 stainless steel. It provides good corrosion and oxidation resistance at high temperature.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Proper preheat at 200 ~ 400°C and PWHT at 730 ~ 760°C.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.061
Manganese (Mn) 0.41
Silicon (Si) 0.45
Phosphorus (P) 0.021
Sulphur (S) 0.012
Nickel (Ni) 0.21
Chromium (Cr) 11.43

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
TS N/mm2 564
EL% 26

HEAT TREATMENT:
750°C X 1hr

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></td>
<td></td>
<td>F, HF</td>
<td>V-UP, OH</td>
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<tr>
<td>Welding Position</td>
<td></td>
<td></td>
<td></td>
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<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>
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