DESCRIPTION:
SFC-70C is a metal cored wire designed for high speed horizontal fillet welding with CO2 gas on primed plate (inorganic primer coated) with excellent pit resistance, stable arc, less spatter and smooth weld bead.

APPLICATIONS:
It is widely used for flat and horizontal fillet welding in shipbuilding, bridges, vehicle, machinery and structural fabrication etc.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Control the inter-pass temperature below 150°C for multi-layer welding

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.047
Manganese (Mn) 1.25
Silicon (Si) 0.42
Phosphorus (P) 0.013
Sulphur (S) 0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 467
TS N/mm² 554
EL % 27

TYPICAL IMPACT VALUES:
IV -20°C J 70

APPROVALS:
BV, DNV · GL, NK, JIS

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
<th>1.4mm</th>
<th>1.6mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Welding Position</td>
<td>F</td>
<td>HF</td>
<td>H</td>
<td>HF</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 36</td>
<td>25 ~ 38</td>
<td>28 ~ 38</td>
<td>28 ~ 38</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>180 ~ 300</td>
<td>180 ~ 380</td>
<td>180 ~ 380</td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td>20 ~ 30</td>
<td></td>
</tr>
<tr>
<td>Flow Rate (L/min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td>20 ~ 25</td>
<td></td>
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</tbody>
</table>