SFC-71J

FLUX CORED WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION:
SFC-71J is an all-position flux cored mild steel wire designed to produce superior mechanical properties that reach the impact value requirements under -40°C. SFC-71J has excellent welder appeal because its’ smooth stable arc yields virtually spatterless weld deposits and generates very little fume.

APPLICATIONS:
It is widely used for shipbuilding, storage vessels, structural fabrication, machinery and piping, etc.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:

![Welding Positions Diagram]

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%)
Weld Metal Analysis:
- Carbon (C) 0.050 0.042
- Manganese (Mn) 1.25 1.44
- Silicon (Si) 0.37 0.46
- Phosphorus (P) 0.009 0.010
- Sulphur (S) 0.005 0.004
- Shielding Gas CO₂ 80%Ar+20%CO₂

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
- YP N/mm² 535 547
- TS N/mm² 560 580
- EL% 30 28
- Shielding Gas CO₂ 80%Ar+20%CO₂

TYPICAL IMPACT VALUES:
- IV -50°C J 75 81
- Shielding Gas CO₂ 80%Ar+20%CO₂

APPROVALS:
ABS, LR, CE, JIS

SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>1.2mm</th>
<th>1.4mm</th>
<th>1.6mm</th>
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<tbody>
<tr>
<td>Diameter (mm)</td>
<td>1.2mm</td>
<td>1.4mm</td>
<td>1.6mm</td>
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<tr>
<td>Welding Position</td>
<td>Flat</td>
<td>Vertical-up</td>
<td>Flat</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>22 ~ 34</td>
<td>22 ~ 30</td>
<td>24 ~ 36</td>
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<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>150 ~ 250</td>
<td>180 ~ 350</td>
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<tr>
<td>Stickout (mm)</td>
<td>10 ~ 15</td>
<td>15 ~ 20</td>
<td>15 ~ 20</td>
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<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td>20 ~ 25</td>
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