DESCRIPTION:
SFC-71Ni is an all-positional rutile flux cored wire designed to be used with CO2 gas. It performs stable arc, low spatter level, good slag removal and excellent toughness at -40°C.

APPLICATIONS:
It is widely used for welding 490 N/mm² a steels in shipbuilding, off-shore plateform, low temperature serving storage tanks, harbor equipment 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:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.048
Manganese (Mn) 1.35
Silicon (Si) 0.46
Phosphorus (P) 0.018
Sulphur (S) 0.009
Nickel (Ni) 0.37

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 492
TS N/mm² 550
EL% 28

TYPICAL IMPACT VALUES:
IV -40°CJ 74

APPROVALS:
-

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>1.2mm</th>
<th>1.6mm</th>
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</thead>
<tbody>
<tr>
<td>Diameter (mm)</td>
<td></td>
<td></td>
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<tr>
<td>Welding Position</td>
<td>F</td>
<td>F</td>
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<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 36</td>
<td>30 ~ 40</td>
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<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>200 ~ 400</td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>15 ~ 25</td>
<td>20 ~ 30</td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>20 ~ 25</td>
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</tbody>
</table>