DESCRIPTION:
SFC-71 is an all-positional rutile flux cored wire designed to be used with CO2 or Ar/CO2 gas mixture. It can be used on all-position welds with both single and multiple pass welds for mild steel and low alloy steels.

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]

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%): (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.051
Manganese (Mn) 1.36
Silicon (Si) 0.48
Phosphorus (P) 0.012
Sulphur (S) 0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 474
TS N/mm² 573
EL% 28

TYPICAL IMPACT VALUES:
IV -20°C J 92

APPROVALS:
ABS,BV,CCS,CE,CR,DNV · GL,LR,NK,KR,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></td>
<td></td>
<td>Flat</td>
<td>Vertical-up</td>
<td>Flat</td>
</tr>
<tr>
<td>Welding Position</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td></td>
<td>28 ~ 36</td>
<td>25 ~ 26</td>
<td>28 ~ 38</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>150 ~ 300 150 ~ 220</td>
<td>180 ~ 350</td>
<td>150 ~ 230</td>
<td>200 ~ 400</td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>10 ~ 15</td>
<td>15 ~ 20</td>
<td>15 ~ 30</td>
<td></td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
</tr>
</tbody>
</table>

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