DESCRIPTION:
SFC-721 is a self-shielded flux cored wire designed for vertical up, one pass welding with high deposition rate of consumable guide self-shielded electro-gas welding (EGW) process.

APPLICATIONS:
It is designed for one pass, vertical up welding of shipbuilding, heavy shop fabrication and structural welding, boxes.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Keep the welding parts clean, out of moisture before welding.
3. Pre-heat the workpiece and welding zone.
4. Consumable guide tube material chemistry close to deposit metal is recommended.
5. Recommended base metal thickness range 19-100mm.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.08
Manganese (Mn) 1.32
Silicon (Si) 0.26
Phosphorus (P) 0.018
Sulphur (S) 0.010
Aluminum (Al) 0.12

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
YP N/mm² 485
TS N/mm² 580
EL% 25

TYPICAL IMPACT VALUES:
IV -20°C J 56

APPROVALS:

SUGGESTED WELDING PARAMETERS (DC <->):

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>3.0mm</th>
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<tbody>
<tr>
<td>Thickness (mm)</td>
<td>19</td>
<td>25</td>
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<tr>
<td>WFS (cm/min)</td>
<td>510</td>
<td>580</td>
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<tr>
<td>Voltage (volt)</td>
<td>34 ~ 37</td>
<td>38 ~ 41</td>
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