DESCRIPTION:
SFC-81A1 is a 0.5% molybdenum alloyed rutile flux cored wire whose weld metal analysis is similar to an E7018-A1 low hydrogen electrode. In conjunction with 100%CO2 shielding gas, it performs good weldability in all positions involved good bead appearance, less spatter and stable arc.

APPLICATIONS:
It is suitable for welding high-strength and matching creep-resisting steels.

NOTE ON USAGE:
1. Use 100%CO2.
2. Proper preheat at 100 ~ 200°C and PWHT at 620 ~ 680°C.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) (Shielding Gas: 100% CO2)
Weld Metal Analysis:
- Carbon (C) 0.051
- Manganese (Mn) 1.05
- Silicon (Si) 0.46
- Phosphorus (P) 0.018
- Sulphur (S) 0.009
- Molybdenum (Mo) 0.55

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
- YP N/mm² 596
- TS N/mm² 643
- EL% 24

HEAT TREATMENT:
620°C X 1hr

APPROVALS:
-

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>1.2mm</th>
<th>1.6mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>25 ~ 35</td>
<td>30 ~ 40</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 330</td>
<td>300 ~ 400</td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
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</tbody>
</table>