DESCRIPTION:
SFC-81B2 is a rutile flux cored wire designed for welding of 1~1.25%Cr-0.5%Mo low alloy steel. 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 Cr-Mo steel pipe and Cr-Mo steel with requirement of high creep resistance.

NOTE ON USAGE:
1. Use 100%CO2.
2. Proper preheat at 150 ~ 300°C and PWHT at 650 ~ 700°C.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):(Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.055
Manganese (Mn) 0.92
Silicon (Si) 0.42
Phosphorus (P) 0.021
Sulphur (S) 0.010
Chromium (Cr) 1.12
Molybdenum (Mo) 0.61

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
YP N/mm2 552
TS N/mm2 628
EL% 21

HEAT TREATMENT:
690°C X 1hr

APPROVALS:
-

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</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>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 330</td>
<td>300 ~ 400</td>
<td></td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
</tr>
</tbody>
</table>