DESCRIPTION:
SFC-81K2 is an all position flux cored wire whose weld metal contains about 1.5%Ni to attain low temperature requirement down to -60°C. In conjunction with 100%CO2 shielding gas, it provides excellent mechanical property, good weldability of smooth arc and less spatter.

APPLICATIONS:
It is suitable for butt or fillet welding application for LNG and LPG carriers, storage tanks and low temperature service steels.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Proper heat input can obtain the required impact value.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):(Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.040 0.036
Manganese (Mn) 1.26 1.46
Silicon (Si) 0.38 0.42
Phosphorus (P) 0.021 0.016
Sulphur (S) 0.006 0.006
Nickel (Ni) 1.46 1.48
Shielding Gas CO2 80%Ar+20%CO2

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO2)
YP N/mm2 520 565
TS N/mm2 604 626
EL% 27 28
Shielding Gas CO2 80%Ar+20%CO2

TYPICAL IMPACT VALUES:
IV -60°C J 51 62
Shielding Gas CO2 80%Ar+20%CO2

APPROVALS:
BV,DNV,GL

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>
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</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Flat</td>
<td>Vertical-up</td>
<td>Flat</td>
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<tr>
<td>Welding Position</td>
<td></td>
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<td></td>
<td></td>
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<tr>
<td>Voltage (Volt)</td>
<td></td>
<td>22 ~ 34</td>
<td>22 ~ 30</td>
<td>24 ~ 36</td>
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<tr>
<td>Current (Amp)</td>
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<td>150 ~ 300</td>
<td>150 ~ 250</td>
<td>180 ~ 350</td>
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<tr>
<td>Stickout (mm)</td>
<td></td>
<td>10 ~ 15</td>
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<td>15 ~ 20</td>
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<tr>
<td>Flow Rate (l / min)</td>
<td></td>
<td>15 ~ 25</td>
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<td>15 ~ 25</td>
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