DESCRIPTION:
SFC-81W2 is a flux cored wire designed for all-positional welding. In conjunction with 100% CO2 shielding gas, it provides excellent mechanical property, but also good weldability of stable arc less spatter and smooth bead appearance.

APPLICATIONS:
It is suitable for butt or fillet MAG welding application for ASTM A588, A242 without painting and 550N/mm² weather-proof steel.

NOTE ON USAGE:
1. Use 100% CO2.
2. Proper heat input can obtain the required impact value.
3. Preheat and interpass temperature between 50~150°C

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.04
Manganese (Mn) 1.18
Silicon (Si) 0.55
Phosphorus (P) 0.018
Sulphur (S) 0.012
Nickel (Ni) 0.48
Chromium (Cr) 0.55
Copper (Cu) 0.41

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 594
TS N/mm² 658
EL% 25

TYPICAL IMPACT VALUES:
IV -30°C J 53

APPROVALS:
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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></td>
<td>25 ~ 35</td>
<td>30 ~ 40</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>250 ~ 330</td>
<td>300 ~ 400</td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td></td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
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</tbody>
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