DESCRIPTION:
SFC-91B3 is an all-positional flux cored wire designed for welding of 2~2.25%Cr-1%Mo low alloy steel. In conjunction with 100%CO2 shielding gas, it performs good weldability 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 200 ~ 350°C and PWHT at 680 ~ 730°C.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas: 100% CO2)
Weld Metal Analysis:
Carbon (C) 0.06
Manganese (Mn) 0.950
Silicon (Si) 0.310
Phosphorus (P) 0.018
Sulphur (S) 0.090
Chromium (Cr) 2.360
Molybdeum (Mo) 1.110

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO2)
YP N/mm² 635
TS N/mm² 699
EL% 20

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></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>
</tr>
</tbody>
</table>