DESCRIPTION:
SFC-81M is a metal cored wire designed for high speed horizontal fillet welding with CO2 gas or mix gas on primed plate (inorganic primer coated) with excellent pit resistance, stable arc, less spatter, less slag and smooth weld bead.

APPLICATIONS:
It is widely used for flat and horizontal fillet welding in shipbuilding, bridges, vehicle, machinery and structural fabrication etc.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Control the inter-pass temperature below 150°C for multi-layer welding

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt.%):
Weld Metal Analysis:
Carbon (C) 0.036 0.032
Manganese (Mn) 1.21 1.42
Silicon (Si) 0.36 0.44
Phosphorus (P) 0.006 0.006
Sulphur (S) 0.005 0.006
Nickel (Ni) 1.32 1.34
Shielding Gas CO2 80%Ar+20%CO2

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
YP N/mm2 535 585
TS N/mm2 603 621
EL% 30 27
Shielding Gas CO2 80%Ar+20%CO2

TYPICAL IMPACT VALUES:
IV -60°C J 55 67
Shielding Gas CO2 80%Ar+20%CO2

APPROVALS:

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>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Flat</td>
<td>Flat</td>
<td>Flat</td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td>22 ~ 34</td>
<td>24 ~ 36</td>
<td>26 ~ 38</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>180 ~ 350</td>
<td>200 ~ 400</td>
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<tr>
<td>Stickout (mm)</td>
<td>10 ~ 15</td>
<td>15 ~ 20</td>
<td>15 ~ 30</td>
<td></td>
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<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td>20 ~ 25</td>
<td></td>
</tr>
</tbody>
</table>

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