DESCRIPTION:
SFC-308B contains right amount of ferrit in the weld metal delivers low crack sensitivity. Hardly any Bi constituent, the weld metal turn out to have less chance of crack because of ductility increased for high temperature working environments. Soft arc transfer, low spatters, excellent bead appearance enhance the weldability to achieve your work easier.

APPLICATIONS:
It is designed to weld 18%Cr-8%Ni stainless steel i.e. SUS304, 304L. Especially for the high working temp. like solution treatment. Petrochemical, pressure vessels, food machinery, medical machinery, textile machinery, etc applications.

NOTE ON USAGE:
1. Welding parts is required to be clean from dust, oil, and rusty.
2. Use 100% CO2 gas with G.F.R 15-25l/min and the gas purity requested 99.8% min.
3. DC (+) welding.
4. Take necessary protection for proper gas shielding during welding for ductility without porosity and less content of nitrogen & hydrogen.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.05
Manganese (Mn) 1.17
Silicon (Si) 0.51
Nickel (Ni) 10.18
Chromium (Cr) 19.45
Phosphorus (P) 0.023
Sulphur (S) 0.001
Bismuth (Bi) ≤10ppm

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
TS N/mm² 601
EL% 44

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2</th>
<th>1.6</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>20~36</td>
<td>24~38</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>120~260</td>
<td>200~300</td>
<td></td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>15 ~ 25</td>
<td>18 ~ 25</td>
<td></td>
</tr>
<tr>
<td>Flow Rate (l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
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</tbody>
</table>