FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION:
SFC-309LB contains ferrite in the deposit metal delivers less crack resistance. Hardly any Bi constituent, the weld metal turns out to have less chance of crack because of ductility increased for high temperature working environments. Soft arc transfer, low spatters, and excellent bead appearance.

APPLICATIONS:
It is recommended to weld carbon steel to stainless steel or low alloy steel to stainless steel. Also suitable for buttering upon carbon steel or low alloy steel to get grade 308(L) deposit metal.

NOTE ON USAGE:
1. Clean up the base metal to be free from contamination (rust, moisture, oil, dust, etc.)
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) 0.023
Manganese (Mn) 1.18
Silicon (Si) 0.51
Nickel (Ni) 12.73
Chromium (Cr) 23.08
Phosphorus (P) 0.025
Sulphur (S) 0.003
Bismuth (Bi) ≤10ppm

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
TS N/mm² 570
EL% 42

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></td>
<td>20~36</td>
<td>24~38</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>120~260</td>
<td>200~300</td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td></td>
<td>15 ~ 25</td>
<td>18 ~ 25</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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