DESCRIPTION:
SFC-316LB 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. This wire also contains Mo provides good corrosion resistance.

APPLICATIONS:
It is designed to weld 18%Cr-12%Ni-2%Mo stainless steel i.e. SUS316, 316L. Especially for high working temp. like solution treatment. Petrochemical, pressure vessels, food machinery, medical machinery, textile machinery, etc applications.

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) 1.10
- Silicon (Si) 0.60
- Nickel (Ni) 12.15
- Chromium (Cr) 18.77
- Phosphorus (P) 0.022
- Sulphur (S) 0.000
- Molybdenum (Mo) 2.35
- Bismuth (Bi) ≤10ppm

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
- TS N/mm2 583
- EL% 37

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

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