DESCRIPTION:
SFC-347LB contains Nb delivers superior grain boundary corrosion resistance. Hardly any Bi constituent, the weld metal delivers low crack sensitivity, and 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. i.e. 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) 0.026
Manganese (Mn) 1.10
Silicon (Si) 0.64
Nickel (Ni) 10.13
Chromium (Cr) 19.54
Phosphorus (P) 0.023
Sulphur (S) 0.003
Niobium(Nb) 0.45
Bismuth (Bi) 10ppm

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:
TS N/mm2 620
EL% 43

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