

SUBMERGED ARC WELDING STRIP AND FLUX FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFB-E300 is an agglomerated flux with low dilution characteristic. It is designed for combination with SB-308L, SB-309L, SB-316L strips.
- Suitable for petrochemical, urea and nuclear equipment and offshore platform.

NOTE ON USAGE :

- Re bake flux at 300~350°C for 1hour after opening use.
- Appropriate new flux is required to add with the recycling used flux to maintain welding quality.
- Recommended keep welding position between horizontal to 1° from work piece.
- Thickness of build up layer between 4~5mm. Once thickness over than 5mm, welding bead would be get under cut easily.
- Do not spread flux on the slag behind the welding direction.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

Item	Composition	C	Mn	Si	P	S	Ni	Cr	Mo
SB-309L	Strip	0.016	1.84	0.32	0.017	0.008	13.75	23.51	-
	1 st layer	0.023	1.32	0.45	0.019	0.004	12.58	20.72	-
SB-308L	Strip	0.015	1.86	0.29	0.020	0.007	9.43	21.08	-
	2 nd layer	0.019	1.33	0.42	0.021	0.005	11.83	20.45	-
SB-316L	Strip	0.018	1.91	0.26	0.019	0.008	13.11	19.12	2.61
	2 nd layer	0.021	1.45	0.42	0.020	0.006	12.73	19.25	2.42

SIZE AND RECOMMENDED CURRENT RANGE : (DC+)

Strip size (mm)	Current (Amp)	Voltage (Volt)	W.F.S. (mm/min)	Stickout (mm)	Thickness (mm)
0.5×60	700~1000	24~30	140~220	30~40	20~30
0.4×50	550~800	24~30	140~220	30~40	15~25