

## SUBMERGED ARC WELDING STRIP AND FLUX FOR STAINLESS STEEL

### DESCRIPTION & APPLICATIONS :

- SFB-S300 is an agglomerated flux designed for combination with SB-308L, SB-309L and SB-316L strips.
- It can provide excellent weldability, easy slag removal, smooth bead appearance and excellent corrosion resistance.
- 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.

### 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 <sup>st</sup> layer	0.024	1.25	0.53	0.021	0.005	11.83	20.22	-
SB-308L	Strip	0.015	1.86	0.29	0.020	0.007	9.43	21.08	-
	2 <sup>nd</sup> layer	0.025	1.43	0.65	0.022	0.006	9.86	19.25	-
SB-316L	Strip	0.018	1.91	0.26	0.019	0.008	13.11	19.12	2.61
	2 <sup>nd</sup> layer	0.020	1.41	0.53	0.021	0.009	12.61	19.13	2.27

### SIZE AND RECOMMENDED CURRENT RANGE : (DC+)

Strip size (mm)	Current (Amp)	Voltage (Volt)	W.F.S. (mm/min)	Stickout (mm)
0.5×60	700~1000	28~32	140~220	30~40
0.4×50	550~800	28~32	140~220	30~40