

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-309L is an austenitic structure, the weld metal contains 22%Cr-12%Ni the austenitic structure.
- Contains more ferritic structure for anti-cracking, weldability, corrosion and heat resistances.
- It is suitable for dissimilar joints welding in stainless steel and carbon steel; the SUS 304 composite steel overlay bottom welding.

NOTE ON USAGE :

- Use CO₂ within gas purity of 99.8% upward for gas shield, and the flow with 20~25 l/min.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (CO₂)

C	Mn	Si	P	S	Ni	Cr
0.031	1.30	0.65	0.022	0.004	12.80	23.20

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -40 °C J(Kgf-m)
550(56.1)	38	40(4.1)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	1.2		1.6	
	F, H	V, OH	F, H	V, OH
Voltage (Volt)	23-36	22-26	28-36	-
Current (Amp)	130-250	120-160	180-300	-