

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-312M contains more ferrite in the austenitic structure suitable for dissimilar joints welding in stainless steel and carbon steel, and better anti-cracking than SFC-312.
- Contains more ferrite than 309 series suitable for high carbon steel and low alloy steel on 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	Others
0.030	1.00	0.55	0.025	0.003	8.30	27.00	1.6

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
810(82.7)	23

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	-