

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-317L is an austenitic structure, the weld metal contains 19%Cr-12%Ni-3%Mo.
- Advantage of organic acid, sulfuric acid/sulphuric acid in corrosion resistance.
- It is suitable for chemical container such as AISI 316/316L, 317/317L, and SUS 317L steels.

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	Mo
0.03	1.10	0.48	0.021	0.006	13.11	19.30	3.61

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES 0 °C J(Kgf-m)
600(61.2)	30	35(3.6)

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	—