

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-318 is an austenitic structure, the weld metal contains 18%Cr-12%Ni-2%Mo-Ti(Nb).
- Contains Mo, features non-oxidative acid of dilute sulfuric acid advantageous to anti-corrosion, besides, within an addition of Nb is advantage of intergranular corrosion and heat resistance.
- It is suitable for chemical container such as AISI 316Ti, and SUS 316Ti 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	Nb
0.03	1.14	0.60	0.030	0.005	12.12	18.53	2.50	0.49

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -40 °C J(Kgf-m)
590(60.2)	32	47(4.8)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	Diameter (mm)	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	-