

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-347L is an austenitic structure, the weld metal contains 19%Cr-9%Ni-Ti(Nb).
- Within an addition of Nb is advantage of intergranular corrosion and well creep strength at high temp.
- It is suitable for AISI 347, 321, 304L, and SUS 347, 321, 304L 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	Nb
0.031	1.10	0.62	0.030	0.004	10.28	19.50	0.48

TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -40 °C J(Kgf-m)
610(62.2)	37	48(4.9)

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	-