

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-71 is a 490N/mm² grade titania flux cored wire.
- It performs very little fume, stable arc, less spatter, good slag removable, good weld bead appearance and excellent toughness.
- It is widely used for ship building, storage vessels, structural fabrication, machinery and piping, etc.

NOTE ON USAGE :

- Use CO₂ shielding gas with flow rate 15~25 l/min. Once use for Mix shielding gas with 75~80%Ar + 20~25%CO₂ would be taken excellent management.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : 100% CO₂)

C	Mn	Si	P	S
0.051	1.36	0.48	0.012	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 100% CO₂)

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -20 °C J(Kgf-m)
510(52.0)	573(58.5)	28	92(9.4)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2		1.4		1.6	
	F	Vertical-up	F	Vertical-up	F	Vertical-up
Voltage(Volt)	22-36	22-28	22-38	21-29	24-40	22-30
Current (Amp)	150-300	150-220	180-350	150-230	200-400	160-250
Stickout(m/m)	10-15		15-20		15-30	
Flow Rate(l/min)	15-25		15-25		15-25	