

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-71B is a self-shielded flux cored wire designed for 490Mpa grade with all-positional welding.
- Very easy for carrying, could be used for single or multiple pass weld, with stable arc and less spatter.
- Suitable for thin-gauge galvanized and mild steel welding.

NOTE ON USAGE :

- PWHT at 200°C×12hr.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Al
0.090	0.69	0.44	0.008	0.003	1.30

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %
420(42.9)	570(58.2)	25

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Parameters					
Voltage(Volt)	17-19	17-20	18-23	18-24	18-24
Current (Amp)	100-150	100-160	120-230	140-250	160-260
Stickout(m/m)	10-15	10-15	10-15	10-15	10-15