

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-71G is a self-shielded flux cored wire designed for single pass with DC(-) usage.
- Good penetration, high deposition rate, good X-Ray soundness, slag removal easily and nice welding bead appearance.
- Suitable for machinery, steel structure welding and heavy steel structure maintenances.

NOTE ON USAGE :

- Use DC (-) polarity.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Al
0.20	1.20	0.20	0.009	0.004	2.50

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %
504(51.4)	576(58.7)	24

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Parameters \ Diameter (mm)	0.8	0.9	1.0	1.2	1.6
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