

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-71J is a 490N/mm² grade flux cored wire designed to be used with CO₂ shielding gas.
- It is very well on all-positional management. And performance very little fume, stable arc, less spatter, nice bead appearance, good slag removal and excellent toughness at -40°C.
- It is widely used for ship building, low temperature serving storage tanks, pipings 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
0.045	1.20	0.42	0.012	0.006

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 -40 °C J(Kgf-m)
520(53.1)	570(58.1)	29	90(9.2)

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)	23-36	23-28	23-38	22-29	23-40	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	