

FLUX CORE WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION & APPLICATIONS :

- SFC-75 is a 490N/mm² grade flux cored wire designed to be used with CO₂ or Ar/CO₂ gas mixture.
- All-positional management with less fumes, stable arc, less spatter, nice welding bead appearance slag removal, good X-Ray soundness and excellent toughness at -30°C.
- It is widely used for shipbuilding, storage vessel, machinery, bridges, steel structure 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
0.045	1.3	0.45	0.021	0.013

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 -30 °C J(Kgf-m)
495(50.5)	550(56.1)	28	93(9.5)

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)	25-36	25-28	28-38	25-29	30-40	26-30
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	