

SFC-110

AWS A5.29 E111T1-GC/GM
JIS –
EN –

FLUX CORED WIRES FOR $\geq 550\text{N/mm}^2$ HIGH TENSILE STEEL

DESCRIPTION :

SFC-110 is a gas-shielded high tensile strength flux cored wire designed for high tensile steel carries 780N/mm^2 , suitable for all-positional welding.

APPLICATIONS :

It is designed for petro chemical industry, oil refinery components, pipes.

NOTE ON USAGE :

1. Use DC (+) polarity. CO₂ gas (min. 99.8%) G.F.R: 15~25 l/min
2. Keep the welding parts clean, out of moisture before welding.
3. Pre-heat the workpiece at temp. 220~350°C
4. Proper protection from wind during welding, reduce the H₂ and N pick up.

WELDING POSITION:



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

Weld Metal Analysis :

Carbon (C)	0.047
Manganese (Mn)	1.42
Silicon (Si)	0.32
Phosphorus (P)	0.014
Sulphur (S)	0.009
Nickle (Ni)	2.76
Molybdenum (Mo)	0.47

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

YP N/mm ²	658
TS N/mm ²	801
EL%	21

TYPICAL IMPACT VALUES :

IV -40°C J	42
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APPROVALS :

ABS

SUGGESTED WELDING PARAMETERS (DC <+>)

Diameter (mm)	1.2mm	1.6mm
Parameters		
Voltage (Volt)	25 ~ 35	30 ~ 40
Current (Amp)	250 ~ 330	300 ~ 400