

SFC-71G

AWS A5.20 E71T-G
JIS Z3313 T 49 TG-1 N A
EN ISO 17632-A T42 Z Y N 1

FLUX CORED WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION :

SFC-71G is a self-shielded flux cored wire designed for the welding of thin-gauge galvanised and mild steels in all positions. Slag removal is easy with less spatter.

APPLICATIONS :

This wire is used for mild steel and 490N/mm² high tensile steel.

NOTE ON USAGE :

1. Use DC - polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

WELDING POSITION:



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

Weld Metal Analysis :

Carbon (C)	0.140
Manganese (Mn)	1.35
Silicon (Si)	0.61
Phosphorus (P)	0.018
Sulphur (S)	0.006
Aluminium (Al)	1.14

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:

YP N/mm ²	504
TS N/mm ²	576
EL%	24

APPROVALS :

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SUGGESTED WELDING PARAMETERS (DC <->)

Parameters	Diameter (mm)		1.2mm		1.6mm	
	Flat	Vertical-up	Flat	Vertical-up	Flat	Vertical-up
Welding Position	Flat	Vertical-up	Flat	Vertical-up	Flat	Vertical-up
Voltage (Volt)	30 ~ 36	25 ~ 26	30 ~ 45	26 ~ 30		
Current (Amp)	250 ~ 330	150 ~ 220	300 ~ 450	160 ~ 250		
Stickout (mm)	10 ~ 15		15 ~ 30			
Flow Rate (l / min)	15 ~ 25		15 ~ 25			