

# SFC-71M

AWS A5.18 E70C-6C/6M  
JIS Z3313 T 49 2 T15-0 C/M A-U  
EN ISO 17632-A T42 4 M C/M 3 H5

## FLUX CORED WIRES FOR 490N/mm2 HIGH TENSILE STEEL

### DESCRIPTION :

SFC-71M is a metal cored wire designed for high speed horizontal fillet welding with CO2 gas or mix gas on primed plate (inorganic primer coated) with excellent pit resistance, stable arc, less spatter and smooth weld bead.

### APPLICATIONS :

It is widely used for flat and horizontal fillet welding in shipbuilding, bridges, vehicle, machinery and structural fabrication etc.

### NOTE ON USAGE :

1. Use DC (+) polarity.
2. Control the inter-pass temperature below 150°C for multi-layer welding

### WELDING POSITION:



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%)

Weld Metal Analysis :

Carbon (C)	0.046	0.042
Manganese (Mn)	1.23	1.42
Silicon (Si)	0.35	0.47
Phosphorus (P)	0.013	0.008
Sulphur (S)	0.005	0.006
Shielding Gas	CO2	80%Ar+20%CO2

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL:

YP N/mm2	466	549
TS N/mm2	530	590
EL%	31	26
Shielding Gas	CO2	80%Ar+20%CO2

### TYPICAL IMPACT VALUES :

IV -50°C J	56	64
Shielding Gas	CO2	80%Ar+20%CO2

### APPROVALS :

ABS,CE,LR

### SUGGESTED WELDING PARAMETERS (DC <+>)

Diameter (mm)	1.2mm	1.4mm	1.6mm
Parameters			
Welding Position	Flat	Flat	Flat
Voltage (Volt)	22 ~ 34	24 ~ 36	26 ~ 38
Current (Amp)	150 ~ 300	180 ~ 350	200 ~ 400
Stickout (mm)	10 ~ 15	15 ~ 20	15 ~ 30
Flow Rate (l / min)	15 ~ 25	15 ~ 25	20 ~ 25