

SFC-75

AWS A5.20 E71T-5C/5M
JIS Z3313 T 49 3 T5-1 C/M A-U
EN ISO 17632-A T42 3 B C/M 1 H5

FLUX CORED WIRES FOR 490N/mm² HIGH TENSILE STEEL

DESCRIPTION :

SFC-75 is an all-positional rutile flux cored wire designed to be used with CO₂ or Ar/CO₂ gas mixture. It can obtain better impact toughness than E71T-1 in low temperature.

APPLICATIONS :

It is commonly used for shipbuilding, structural fabrication and machinery. piping,etc.

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%) :(Shielding Gas: 100% CO₂)

Weld Metal Analysis :

Carbon (C)	0.045
Manganese (Mn)	1.30
Silicon (Si)	0.45
Phosphorus (P)	0.021
Sulphur (S)	0.013

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

YP N/mm ²	495
TS N/mm ²	570
EL%	28

TYPICAL IMPACT VALUES :

IV -30°C J	93
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APPROVALS :

DNV · GL,LR,CE

SUGGESTED WELDING PARAMETERS (DC <+>)

Parameters	1.2mm		1.4mm		1.6mm	
	Flat	Vertical-up	Flat	Vertical-up	Flat	Vertical-up
Welding Position	Flat	Vertical-up	Flat	Vertical-up	Flat	Vertical-up
Voltage (Volt)	28 ~ 36	25 ~ 26	28 ~ 38	25 ~ 28	30 ~ 40	26 ~ 30
Current (Amp)	150 ~ 300	150 ~ 220	180 ~ 350	150 ~ 230	200 ~ 400	160 ~ 250
Stickout (mm)	10 ~ 15		15 ~ 20		15 ~ 30	
Flow Rate (l / min)	15 ~ 25		15 ~ 25		15 ~ 25	