

# SFC-81W2

AWS A5.29 E81T1-W2C  
JIS Z3320 YFA-58W  
EN –

## FLUX CORED WIRES FOR ATMOSPHERIC CORRSION RESISTANT STEEL

### DESCRIPTION :

SFC-81W2 is a flux cored wire designed for all-positional welding. In conjunction with 100%CO<sub>2</sub> shielding gas, it provides excellent mechanical property, but also good weldability of stable arc less spatter and smooth bead appearance.

### APPLICATIONS :

It is suitable for butt or fillet MAG welding application for ASTM A588、A242 without painting and 550N/mm<sup>2</sup> weather-proof steel.

### NOTE ON USAGE :

1. Use 100%CO<sub>2</sub>.
2. Proper heat input can obtain the required impact value.
3. Preheat and interpass temperature between 50~150°C

### WELDING POSITION:



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :(Shielding Gas: 100% CO<sub>2</sub>)

Weld Metal Analysis :

Carbon (C)	0.04
Manganese (Mn)	1.18
Silicon (Si)	0.55
Phosphorus (P)	0.018
Sulphur (S)	0.012
Nickel (Ni)	0.48
Chromium (Cr)	0.55
Copper (Cu)	0.41

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 100% CO<sub>2</sub>)

YP N/mm <sup>2</sup>	594
TS N/mm <sup>2</sup>	658
EL%	25

### TYPICAL IMPACT VALUES :

IV -30°C J	53
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### APPROVALS :

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

Diameter (mm)	1.2mm	1.6mm
Parameters		
Voltage (Volt)	25 ~ 35	30 ~ 40
Current (Amp)	250 ~ 330	300 ~ 400
Flow Rate (l / min)	15 ~ 25	15 ~ 25