

SF-1E

JIS Z 3313 T492T1-1CA-UH5

☆AWS A5.20 E71T-1C

For Mild Steel and 490MPa High Tensile Strength Steel

APPLICATIONS

Welding of mild steel and 490MPa high tensile strength steel for machinery, structures, steel frames, ships, bridges, towers, rolling stock and parts which especially requires toughness.

CHARACTERISTICS

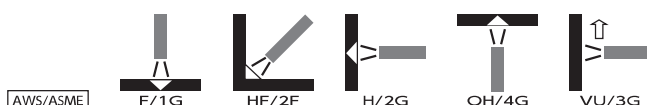
SF-1E is a rutile type seamless flux cored arc welding wire to be used with CO₂ shield gas.

It assures excellent usability with minimized spattering and beautiful bead appearance with satisfactory impact toughness in all position welding.

GUIDELINES FOR USAGE

1. If gas shield is insufficient, nitrogen in the air will be absorbed into weld metal causing deterioration of toughness. Distance between nozzle and base metal should be kept within 20mm.
2. Select optimum welding conditions, heat input for example, in accordance with plate thickness, welding position, etc.
3. For others, see GUIDELINES FOR USAGE 1~4 of SF-1.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Shield Gas	C	Si	Mn	P	S	Ni
CO ₂	0.06	0.50	1.29	0.014	0.005	0.30

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at -20°C, J
590	610	28	93

■ SIZES & RECOMMENDED CURRENT RANGE<DC(+)>

Diameter (mm)		1.2	1.4
Current A	F	180~300	200~410
	H-Fil	180~300	200~410
	H	180~300	200~350
	V-up	180~260	180~260
	OH	180~260	180~260