

SF-1

AWS A5.20 E71T-1C-H4

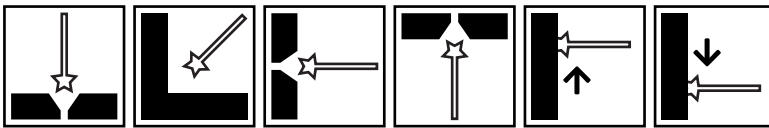
General purpose flux cored wire for mild steel and 490 MPa high tensile strength steel.

GENERAL DESCRIPTION

SF-1 is a rutile type seamless flux cored arc welding wire to be used with CO₂ shielding gas. Arc is stable, spatters are few and bead is smooth with good shape and appearance since easily removable slag covers bead evenly. The diffusible hydrogen content is as low as that of solid wires since the wire has no seam and,

consequently, weld metal shows excellent crack resistance. Low welding fume. High welding efficiency is assured since deposition rate is high and all-position welding is easily performed with almost the same current. This wire is classified as Grade 2 (0 °C).

WELDING POSITIONS



TYPE OF GAS FLOW

100% CO₂
 20-25 l/min

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Shield Gas	C	Si	Mn	P	S			
CO ₂	0.06	0.50	1.40	0.015	0.010			

DIFFUSIBLE HYDROGEN CONTENT: ≤4 ml/100g (2 ml/100g typical)

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield and Tensile Strengths			Charpy 2V-notch, J
Yield MPa	Tensile MPa	Elongation %	0°C
520	580	28	91

GUIDANCE – AMPERE (DC+)

Wire Diameter	1.0 mm	1.2 mm	
Ampere	150-260	180-320	

PACKAGING INFORMATION

1.0mm x 12.5kg spool

SHIPPING APPROVALS

DNV-GL, LR, ABS, BV

REFERENCE

SF-1, English