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WELDING ENGINEERS
EFFICIENT WELDING SUPPLY SOLUTIONS

SF-3AM

EN ISO 17632-A T 46 4 ZMn1Ni P M21 2 H5
AWS A5.29 E81T1-Ni1M-H4

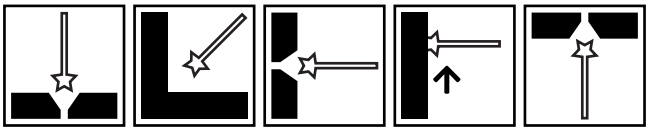
Seamless flux cored wire for low alloyed steel, low temperature service steel applications.

GENERAL DESCRIPTION

SF-3AM is a rutile type seamless flux cored arc welding wire for use with Ar+20%CO_2 shielding gas. Due to the seamless design, the wire has an extremely low diffusible hydrogen content and maintains low level over time which greatly eliminates the risk of hydrogen cracking.
SF-3AM has acceptable charpy impact values down to -60 °C (Ship's Approval Grade 5).

SF-3AM has low visible welding fume, low spatter, and excellent weldability in all positions. The wire has a clean, copper coated surface which, together with exact diameter and roundness, ensures stable and even wire feeding.

WELDING POSITIONS



TYPE OF GAS FLOW

80% Argon/20% CO_2
20-25 l/min

TYPICAL CHEMICAL COMPOSITION OF ALL-WELD-METAL (%)

Shield Gas	C	Si	Mn	P	S	Ni		
Ar+20%CO_2	0.05	0.33	1.28	0.010	0.003	0.89		

DIFFUSABLE HYDROGEN CONTENT: ≤4 ML/100G (2.0 ML/100G TYPICAL)

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield and Tensile Strengths			Charpy 2V-notch, J	
Yield MPa	Tensile MPa	Elongation %	-40°C	-60°C
550	610	27	128	95

GUIDANCE – AMPERE (DC+)

Wire Diameter	1.2 mm	1.4 mm	
Ampere	180-300	200-400	

PACKAGING INFORMATION

1.2mm x 12.5kg spool
1.4mm x 12.5kg spool

SHIPPING APPROVALS

DNV-GL, LR, ABS, BV

REFERENCE

SF-3AM, English

Manufactured by Nippon Steel Welding & Engineering Co. Ltd. Made in Japan