

SF-36E

AWS A5.29 E81T1-K2C-H4 / AWS A5.36 E81T1-C1A8-K2-H4
EN ISO 17632-A: T 46 6 ZMn1.5Ni P C1 2 H5
EN ISO 9606-1: FM1



Flux cored wire for low temperature steels and offshore constructions etc.

General description:

SF-36E is a seamless rutile flux cored wire for welding using 100% CO₂ shielding gas. The deposited weld metal has excellent mechanical properties down to -60°C.

The wire has a stable arc, minimum spatter, good penetration with excellent visual result.

SF-36E is also perfect for root runs against ceramic backing.

Due to its seamless design, the wire has a very low hydrogen content which ensures very low risk of cold cracks.

SF-36E has been CTOD tested at -40°C.

The flux cored wire is copper coated, has a clean surface which together with exact diameter and roundness ensures stable and even wire feeding.

Welding positions:



Welding current:

DC+

Type of gas / flow:

100% CO₂

18-25 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni			
0,04	0,37	1,32	0,016	0,006	0,24	1,53			

Diffusible hydrogen content (ml/100g):

≤5 ml/100g (3,0 ml/100g typical)

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -40 °C	Charpy V (J) -60 °C
570	610	29	112	76

Guidance - Ampere (DC+):

Wire diameter	1,2 mm		
Ampere / Volt	180-300A / 22-32V		

Packaging information:

1,2mm x 12,5kg spool D300

Approvals:

DNV-GL, ABS, LR, BV, CE

Reference / date:

SF-36E, English, 06.07.2023.