SF-36EA

AWS A5.29 E81T1-Ni1M-H4
EN ISO 17632-A: T 46 4 ZMnNi R M21 2 H5
EN ISO 9606-1: FM1

Rutile basic flux cored wire for tough requirements in restraint joints.

General description:

SF-36EA is a seamless rutile basic flux cored wire for welding non- and low alloyed steels with Argon/CO_2 mixed shielding gas. The wire has good weldability with a stable arc, minimum spatter, good penetration and bead appearance.
SF-36EA is your choice if you want a safe alternative against cracks and has very good mechanical properties down to -60°C.
Due to its seamless characteristic, the wire has an extremely low content of hydrogen.
One of the main benefits with this wire is that it has far better results against cracks in restraint joints than normal rutile wires.
The wire can also be used as the root run against ceramic backing.
SF-36EA has documented results in PWHT.
The wire has approvals in all positions although it is most suitable in PA/PB and PC.
The wire has a copper coated smooth surface which together with exact diameter and perfect roundness ensures even and safe wire feeding even with extended conduit cables.

Welding positions:

Welding current:

DC+

Type of gas / flow:

Ar+18-25% CO_2

18-25 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni			
0,06	0,35	1,27	0,007	0,005	0,27	0,85			

Diffusible hydrogen content (ml/100g):

≤5 ml/100g (2,0 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 ºC	Charpy V (J) -40 ºC (PWHT)
560	620	30	106	75

Guidance - Ampere (DC+):

Wire diameter	1,2 mm		
Ampere / Volt	200-300A/22-30V		

Packaging information:

1,2mm x 12,5kg Spool
1,2mm x 5kg Spool

Approvals:

DNV-GL, BV, LR, CE

Reference / date:

SF-36EA, English, 20.04.2026.