SF-47E

AWS A5.29 E81T1-Ni1C-JH4 / AWS A5.36 E81T1-C1A8-Ni1-H4
EN ISO 17632-A: T 46 6 ZMn1Ni P C1 2 H5
EN ISO 9606-1: FM1

Rutile low alloyed Flux cored wire for welding in all positions with impact requirements down to -60°C using 100% CO_2 shielding gas.

General description:

SF-47E is a seamless rutile flux cored wire for welding using 100% CO_2 shielding gas.
SF-47E has excellent weldability, visual bead shape and smooth transition to the base material.
Due to the seamless design the wire has an extremely low diffusible hydrogen content (typical 3 ml/100g) which greatly eliminates the risk of hydrogen cracks.
The wire has a clean copper coated surface which together with exact diameter and roundness ensures stable and even wire feeding.
Wire stick out should be kept approximately 20 mm.
SF-47E has very good mechanical properties including charpy impact values down to -60°C.

Welding positions:

Welding current:

DC+

Type of gas / flow:

100% CO_2

18 - 25 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni			
0,05	0,46	1,31	0,012	0,004	0.29	0,96			

Diffusible hydrogen content (ml/100g):

≤5 ml/100g (3,0 ml/100g typical).

TypicaL Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -60 ºC	
545	600	28	70	

Guidance - Ampere (DC+):

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

Packaging information:

1,2mm x 5,0kg D200
1,2mm x 12,5kg D300

Approvals:

DNV-GL, ABS, LR, CE

Reference / date:

SF-47E, English, 06.07.2023.