

# SF-36E

AWS A5.29 E81T1-GC / 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% CO<sub>2</sub> 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% CO<sub>2</sub>

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<br>Mpa                | Tensile<br>Mpa | Elongation<br>% | Charpy V (J)<br>-40 °C | Charpy V (J)<br>-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, 07.06.2019.