

# SF-47E

AWS A5.29 E81T1-Ni1C-J / 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<sub>2</sub> shielding gas.**

## General description:

SF-47E is a seamless rutile flux cored wire for welding using 100% CO<sub>2</sub> 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<sub>2</sub>

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 °C	
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, CWB, LR, CE

## Reference / date:

SF-47E, English, 07.06.2019.