

SFA T-50

Mild steel wires (FcaW)

Description

SFA T-50 is a tubular wire designed for welding in all position in mono-passed and multi-passed. Uses CO2 or gas mixture 20% - 25% CO2 + Ar as protective gases. Excellent weldability, stable arc and low level of projections. Good appearance of the cord, easy removal of slag. Lower levels of smoke compared to solid wire. Great level of efficiency and productivity due at the high deposition rate.

Classification

AWS A5.20 E71T -9C 9M

AWS A5.36 E71T1-C1 [M21] A2-CS1-H8

IN ISO 17632-A T 46 2 P M21 1 H10

IN ISO T 46 2 P C1 1 H5

Polarity and protection gas

CO2

MIX

DCEP

100% CO2

AR + 20% CO2

(DC+)

Typical weld metal chemical composition (%)

	C	Mn	Si	P	S
CO2	0,04	0,04	0,45	0,01	0,01
MIX GAS	0,05	0,05	0,55	0,015	0,01

All weld metal mechanical properties (typical)

	Yield Strength (N/mm2)	Tensile Strength (N/mm2)	EL (%)	IV (J) -20°C	IV (J) -30°C
CO2	461	544	30,6	101	78
MIX GAS	486	567	32,9	84	60

Applications

Suitable for welding in fillet and stop in mild Steel and in high strength structural steel (490 Mpa). Used in the shipbuilding industry, bridges, metal structure, storage tanks and industrial machinery.

Diameters

1,2 mm

1,4 mm

1,6 mm

Welding positions

