

Applications

Multi layer cladding fluxes for Submerged type stainless 400 series Hardfacing products.

Characteristics on Usage

S-400HF is a submerged arc flux designed for use with Hardfacing wire of the 400 series. It provides smooth bead appearance and excellent hot slag removal. It has excellent recovery of alloying elements of the H.F wire. The weld bead is smooth and uniform.

Notes on Usage

- ① Dry the flux at 300~350°C (572~662°F) for 60 minutes before use.
- ② When the flux height is excessive, poor bead appearance may occur.
- ③ Add new flux periodically to prevent the weld defects and bad bead appearance which occurs when continuously reusing the flux.

Approval

I Current

I Basicity Index

DC +

Typical Chemical Composition of All-Weld Metal (%)

Wire	C	Si	Mn	Cr	Ni	Mo	Nb	W	V
SC-414S	0.10	0.5	1.4	14.9	2.7	1.0	0.20	-	0.4
SC-423S	0.04	0.4	1.3	17.5	3.0	1.2	0.20	-	0.4
SC-420S	0.33	0.8	1.8	12.6	0.5	1.9	0.18	1.4	0.4
SC-420SG	0.29	0.7	1.5	13.9	0.2	-	0.17	-	-

Hardness of Weld Metal

Wire	Dia.(mm)	Hardness (HRc)
SC-414S	2.4/3.2	43-47
SC-423S	3.2	-
SC-420S	3.2	52-56
SC-420SG	3.2	52-56