

SC-42H

Applications

SC-42H is welding for the wearing part between metals such as machines, construction, building, crane wheel, shaft, etc.

Characteristics on Usage

SC-42H is a flux cored wire designed for hardfacing application with 100% CO₂ shielding gas. It is highly recommendable to use on wear and impact between metals. The pure hardness of welded metal is HRC41~44.

Notes on Usage

- ① Preheat at 150°C(302°F) and more than that in general.
- ② Use with 100% CO₂ shielding gas.

Welding Position



1G
(PA)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Mo	V	Nb	Co
0.10	0.50	1.60	4.95	2.60	0.34	0.34	1.05

Typical Mechanical Properties of All-Weld Metal

Preheat temp. °C(°F)	Postheat	Heat Treatment	Hardness(HRC)
150 (302)	-	-	42~44

Approval

I Packing

Dia. (mm)	1.6	Spool(kg)	15
(in)	1/16	(lbs)	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.6(1/16)
F	300~380