

## Applications

For intermetallic abrasion, hardfacing of roller, gear, etc, welding between wear metals.

## Characteristics on Usage

SC-250H is a flux cored wire designed for hardfacing application with 100% CO<sub>2</sub> shielding gas. It is highly recommendable to use on wear plate and weld metal's hardness should be over Hv 250

## Notes on Usage

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

## Welding Position



1G  
(PA)

## Current

DC +

## Shielding Gas

CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr
0.06	0.5	1.6	1.2

## Typical Mechanical Properties of All-Weld Metal

Preheat temp. °C (°F)	Hardness	
	HRc	Hv
150 (302)	25~30	260~300

## Approval

## I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	15
(in)	.045	.052	1/16	(lbs)	33

## Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.6 (1/16)
F	250~350	300~380