

Applications

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

Characteristics on Usage

SC-450H is a flux cored wire designed for hardfacing application with 100% CO₂ shielding gas. It is highly recommendable to use on wear plate and weld metal's hardness should be over Hv 450

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
0.2	0.7	1.5	1.8	0.6

Typical Mechanical Properties of All-Weld Metal

Preheat temp. °C (°F)	Hardness	
	HRc	Hv
150 (302)	45~49	450~500

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)	1.4 (.052)	1.6 (1/16)
F	250~300	280~340	300~380