

## Applications

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

## Characteristics on Usage

SC-600H 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 600

## 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	Mo
0.37	0.5	0.75	4.1	0.58

## Typical Mechanical Properties of All-Weld Metal

Preheat temp.°C (°F)	HRc	Hardness	Hv
150 (302)	55~60		620~660

## Approval

## I Packing

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