

SC-600HM

Applications

For cutting tools, shear blades, rollers for cold rolling mills.

Characteristics on Usage

SC-600HM is a metal cored wire without slag for hardfacing application with Ar-CO₂ mixed gas. It is high resistance to cracking and toughness.

Notes on Usage

- ① Preheat at 150°C(302°F) and more than that in general.
- ② Use with Ar + 20% CO₂ shielding gas.

Welding Position



1G
(PA)

Current

DC +

Shielding Gas

Ar + 20%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Mo
0.5	0.3	1.5	6.5	0.35

Typical Mechanical Properties of All-Weld Metal

Preheat temp. °C(°F)	Postheat	Heat Treatment	Hardness(HRC)
150 (302)	-	-	58-62

Approval

I Packing

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

Sizes Available and Recommended Currents (Amp.)

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