

SC-55S

Description & Applications

For the hardfacing of Steel mill table roll as Martensite alloy
(Steel Mill Rolls - required to get high hardness and abrasion resistance)

Welding Process

SAW Type (with S-717, S-400HF Flux)

Current Type

DC +

Welding Position



1G
(PA)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Mo	W
0.30	0.5	1.6	6.1	1.5	1.5

Hardness

HRc
50-55

Packaging Standard

Dia.(mm)	3.2
Coil(kg)	25
Pailpack(kg)	150, 250

SC-A4S

AWS A5.23 / ASME SFA5.23 F8P2 ECA4-A4

FCAW

Description & Applications

For High strength TMCP or Creep-resistance steels.
(Creep-resistance steels, Fine-grained steels)

Welding Process

SAW Type (with S-717 Flux)

Current Type

DC +

Welding Position



1G
(PA)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Mo
0.10	0.4	1.4	0.5

Typical Mechanical Properties (PWHT)

Y.S MPalbs/in ²	T.S MPalbs/in ²	EL. (%)	Temp. °C (°F)	CVN-Impact Value J(ft.lbs)	Heat Treatment
610 (88,000)	676 (97,000)	24.4	-29 (-20)	70 (52)	600°C (1112°F) × 1hr FC

Packaging Standard

Dia.(mm)	2.4
Coil(kg)	25
Pailpack(kg)	150, 250