

SC-450H

For Hard-facing

Conformances

JIS Z3326 YF2A-C-450

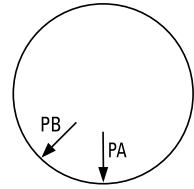
Applications

- Crain wheels, gear, shaft etc.

Features

- Flat and horizontal fillet position welding
- Suitable for metal to metal wear and abrasion parts

Welding Position



Current

DC +

Shielding Gas

100% CO₂ / FCAW process

Diameter / Packaging

Diameter	Spool
mm (in)	15kg (33lbs)
1.2 (0.045)	√
1.4 (0.052)	√
1.6 (1/16)	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo	Others
0.2	0.7	1.7	0.018	0.005	2.2	0.6	-

Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)

450-500

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	9.8 (385)	230	25-27	4.3 (9.4)
		12.5 (492)	260	27-29	5.2 (11.3)
		14.2 (559)	300	29-31	6.0 (13.2)
1.6mm (1/16 in) DC+					
100% CO ₂	20 (4/5)	5.8 (228)	260	27-29	4.8 (10.5)
		7.9 (311)	300	28-30	5.5 (12.1)
		9.7 (381)	330	29-31	7.2 (15.8)

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX