

SC-350H

For Hard-facing

Conformances

JIS Z3326 YF2A-C-350

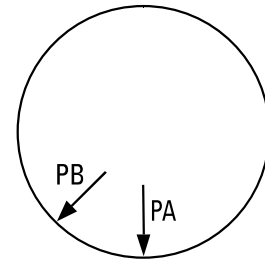
Applications

- Spindle, gear, shaft etc.

Features

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

Welding Position



Current

DC +

Shielding Gas

100% CO₂ / FCAW process

Diameter / Packaging

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

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo	Others
0.12	0.6	1.5	0.010	0.006	1.5	0.5	-

Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)
350~400

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	4.1 (9.0)
		12.5 (492)	260	27~29	5.2 (11.4)
		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	4.7 (10.3)
		7.9 (311)	300	28~30	5.4 (11.9)
		9.7 (381)	330	29~31	7.0 (15.4)