

# SC-414S

Martentic STS Type

## Conformances

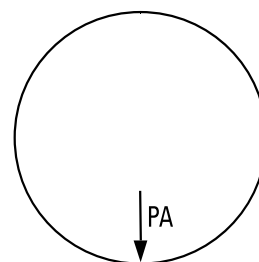
## Applications

- Continuous casting rolls, steel mill rolls

## Features

- Submerged arc type hardfacing wire
- Martensitic stainless steel type

## Welding Position



## Current

DC +

## Welding Process

SAW(with S-717/S-401HF flux)

## Diameter / Packaging

Diameter	Coil	Pac	
mm (in)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
2.4 (3/32)	✓	✓	✓
3.2 (1/8)	✓	✓	✓

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr	Ni	Mo	Nb	V
As welded with 2.4/3.2mm wire	0.11	0.6	1.5	13.8	2.8	1.1	0.2	0.3

## Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)
On Mild Steel (2.4/3.2mm)	42~46

## 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)
3.2mm (1/8in), DC+					
Submerged Arc	25 (1)	1.4 (55)	350	28	3.8 (8.4)
		1.7 (66)	390	30	4.6 (10.1)
		1.8 (72)	430	31	5.2 (11.4)