

SC-55S

Middle Alloy Type

Conformances

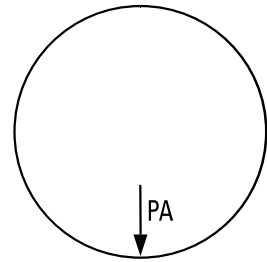
Applications

- Crane wheels, rod wheels, tractor roller

Features

- Submerged arc type hardfacing wire
- Low/Middle alloy type

Welding Position



Current

DC +

Welding Process

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

Diameter / Packaging

Diameter	Coil			Pac	
	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)		
3.2 (1/8)	✓	✓	✓		

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr	Mo	W
As welded with 3.2mm wire	0.3	0.6	2.0	6.5	1.5	1.5

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)
On Mild Steel (3.2mm)	50~55

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 (58)	350	28	4.5 (9.9)
		1.7 (70)	390	30	5.3 (11.6)
		1.9 (76)	430	31	6.0 (13.1)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX