

SC-A4S

Low Alloy Type

Conformances

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

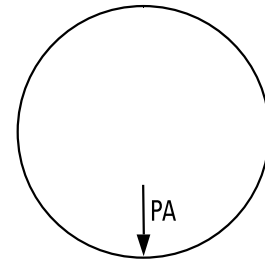
Applications

- High strength steel, creep resisting steel

Features

- Submerged arc type hardfacing wire
- Low alloy 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)	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Mo
As welded with 2.4mm wire	0.10	0.5	1.4	0.5

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	Heat Treatment
As welded with 2.4mm wire	676 (97,000)	24.4	-29 (-20)	70 (52)	600°C (1,112°F) X 1hr FC

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)
2.4mm (3/32in), DC+					
Submerged Arc	25 (1)	3.2 (127)	310	26	3.9 (8.6)
		4.0 (158)	360	28	4.6 (10.1)
		4.6 (181)	410	30	5.1 (11.2)