

# SC-250H

For Hard-facing

## Conformances

JIS Z3326 YF2A-C-250

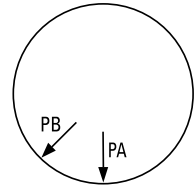
## Applications

- 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% CO<sub>2</sub> / 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
0.06	0.57	1.30	0.011	0.005	1.20	-	-

## Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)

260-300

## 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)
<b>1.2mm (0.045 in) DC+</b>					
100% CO <sub>2</sub>	20 (4/5)	9.8 (385)	230	25-27	4.0 (8.8)
		12.5 (492)	260	27-29	5.1 (11.2)
		14.2 (559)	300	29-31	6.0 (13.2)
<b>1.6mm (1/16 in) DC+</b>					
100% CO <sub>2</sub>	20 (4/5)	5.8 (228)	260	27-29	4.6 (10.1)
		7.9 (311)	300	28-30	5.4 (11.9)
		9.7 (381)	330	29-31	6.9 (15.2)

SM/W

SAW

GM/W

GT/W

FC/W

Non-FERROUS

APPENDIX