

# SC-600H

For Hard-facing

## Conformances

JIS Z3326 YF3B-C-600

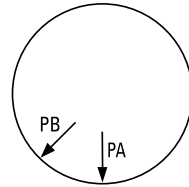
## Applications

- Rollers, shear blades, screw conveyer etc.

## Features

- Flat and horizontal fillet position welding
- Suitable for abrasion 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)	✓
1.4 (0.052)	✓
1.6 (1/16)	✓

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

C	Si	Mn	Cr	Mo	V	W	Others
0.35	0.8	1.6	4.2	0.6	-	-	-

## Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)

620-680

## 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	4.4 (9.7)
		12.5 (492)	260	27-29	5.3 (11.6)
		14.2 (559)	300	29-31	6.1 (13.4)
<b>1.6mm (1/16 in) DC+</b>					
100% CO <sub>2</sub>	20 (4/5)	5.8 (228)	260	27-29	4.9 (10.8)
		7.9 (311)	300	28-30	5.7 (12.5)
		9.7 (381)	330	29-31	7.3 (16.0)