

SC-A4S

Low Alloy Type

Conformances

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

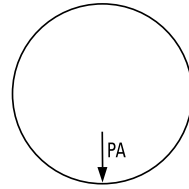
Applications

- 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 |
|------------|-----------------|-------------------|-------------------|
| | 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) |