

# SC-BU Cored

Low Alloy Type

## Conformances

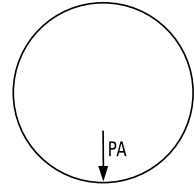
## Applications

- Crain wheels, pulleys

## Features

- Open arc type hardfacing wire(build-up)
- Low alloy type

## Welding Position



## Current

DC +

## Welding Process

Open Arc

## Diameter / Packaging

Diameter mm (in)	Spool		Coil	Pac		
	12.5kg (27.6lbs)	15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
1.2 (0.045)						
1.6 (1/16)						
2.4 (3/32)			✓	✓	✓	
2.8 (7/64)			✓	✓	✓	
3.2 (1/8)						

SM/AW

SAW

GM/AW

GTAW

FC/AW

Non-FERROUS

APPENDIX

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

	C	Si	Mn	Cr
As welded with 2.4/2.8mm wire	0.12	0.8	2.7	1.0

**Typical Mechanical Properties of All-Weld Metal**

	Rockwell Hardness(HRc) (≥3layers)
On Mild Steel (2.4/2.8mm)	25-35

**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>2.4mm (3/32 in) DC+</b>					
Open 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)
<b>2.8mm (7/64in), DC+</b>					
Open Arc	25 (1)	2.9 (114)	330	27	4.9 (10.8)
		3.3 (130)	360	29	5.5 (12.1)
		3.8 (149)	400	30	6.3 (13.8)