

# S-401HF X SC-414S [SC-423S, SC-420S, SC-420SG]

Type : Neutral

## Conformances

EN ISO 14174-S A AB 3

## Applications

- Cladding flux for hardfacing products

## Features

- Smooth and uniform bead appearance
- Good recovery of alloying element of the hardfacing wire
- Density : 1.1g/cm<sup>3</sup>

## Current

AC, DC +

## Basicity Index

## Packages (Flux)

Tin Can 20kg(44lbs)

PE Bag 20kg(44lbs)

## Flux Composition

Consumable	Chemical Composition, wt%			
	SiO <sub>2</sub> + TiO <sub>2</sub>	Al <sub>2</sub> O <sub>3</sub> + MnO	CaO + MgO	CaF <sub>2</sub>
S-401HF	15	25	35	20

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

Wire	C	Si	Mn	Cr	Ni	Mo	Nb	W	V
SC-414S	0.10	0.5	1.4	14.9	2.7	1.0	0.20	-	0.4
SC-423S	0.04	0.4	1.3	17.5	3.0	1.2	0.20	-	0.4
SC-420S	0.33	0.8	1.8	12.6	0.5	1.9	0.18	1.4	0.4
SC-420SG	0.29	0.7	1.5	13.9	0.2	-	0.17	-	-

## Hardness of All-Weld Metal

Wire	Dia.(mm)	Hardness (HRc)
SC-414S	2.4/3.2	43-47
SC-423S	3.2	-
SC-420S	3.2	52-56
SC-420SG	3.2	52-56