

# SC-420SG

Martentic STS Type

## Conformances

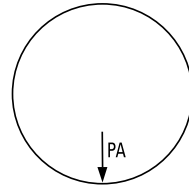
## Applications

- Continuous casting rolls, steel mill rolls

## Features

- Submerged arc type hardfacing wire
- Martensitic stainless steel type

## Welding Position



## Current

DC +

## Welding Process

SAW(with S-717/S-401HF flux)

## Diameter / Packaging

Diameter mm (in)	Coil		Pac
	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)
1.6 (1/16)	√	√	√
2.4 (3/32)	√		
3.2 (1/8)	√	√	√

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

	C	Si	Mn	Cr	Ni	Nb
As welded with 1.6/2.4/3.2mm wire	0.2	0.6	1.5	13.0	0.2	0.15

## Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)
On Mild Steel (1.6/2.4/3.2mm)	48-53

## 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>1.6mm (1/16 in) DC+</b>					
Submerged Arc	25 (1)	4.9 (192)	240	26	2.4 (5.3)
		7.3 (287)	280	29	3.5 (7.7)
		11.2 (440)	330	30	4.4 (9.7)
<b>3.2mm (1/8in), DC+</b>					
Submerged Arc	25 (1)	1.4 (55)	350	28	3.8 (8.4)
		1.7 (66)	390	30	4.5 (9.9)
		1.8 (72)	430	31	5.2 (11.4)