

SC-450H

For Hard-facing

Conformances

JIS Z3326 YF2A-C-450

Applications

- Crain wheels, gear, shaft etc.

Features

- Flat and horizontal fillet position welding
- Suitable for metal to metal wear and abrasion parts

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

100% CO₂ / 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	P	S	Cr	Mo	Others
0.2	0.7	1.5	0.018	0.007	1.8	0.6	-

Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)
450-500

Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	9.8 (385)	25-27	230	4.3 (9.4)
		12.5 (492)	27-29	260	5.2 (11.3)
		14.2 (559)	29-31	300	6.0 (13.2)
1.6mm (1/16 in) DC+					
100% CO ₂	20 (4/5)	5.8 (228)	27~29	260	4.8 (10.5)
		7.9 (311)	28~30	300	5.5 (12.1)
		9.7 (381)	29~31	330	7.2 (15.8)