

SC-600H

For Hard-facing

Conformances

JIS Z3326 YF3B-C-600

Applications

- Rollers, shear blades, screw conveyer etc.

Features

- Flat and horizontal fillet position welding
- Suitable for 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	Cr	Mo	V	W	Others
0.35	0.5	0.7	4.2	0.6	-	-	-

Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)
620-680

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	4.4 (9.7)
		12.5 (492)	27-29	260	5.3 (11.6)
		14.2 (559)	29-31	300	6.1 (13.4)
1.6mm (1/16 in) DC+					
100% CO ₂	20 (4/5)	5.8 (228)	27~29	260	4.9 (10.8)
		7.9 (311)	28~30	300	5.7 (12.5)
		9.7 (381)	29~31	330	7.3 (16.0)

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX