

# SC-700H

For Hard-facing

## Conformances

JIS Z3326 YF3B-C-700

## 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% CO<sub>2</sub> / 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 |
|-----|-----|-----|-----|----|---|-----|--------|
| 0.7 | 0.6 | 1.3 | 5.2 | -  | - | 0.4 | -      |

## Typical Mechanical Properties of All-Weld Metal

Hardness (Hv)

700-720

## Typical Operating Procedures

| Diameter, Polarity<br>Shielding Gas | CTWD<br>mm (in) | Wire Feed Speed<br>m/min (in/min) | Voltage<br>(volts) | Approx. Current<br>(amps) | Deposition Rate<br>kg/hr (lb/hr) |
|-------------------------------------|-----------------|-----------------------------------|--------------------|---------------------------|----------------------------------|
| <b>1.2mm (0.045 in) DC+</b>         |                 |                                   |                    |                           |                                  |
| 100% CO <sub>2</sub>                | 20 (4/5)        | 9.8 (385)                         | 25-27              | 230                       | 4.4 (9.7)                        |
|                                     |                 | 12.5 (492)                        | 27-29              | 260                       | 5.4 (11.9)                       |
|                                     |                 | 14.2 (559)                        | 29-31              | 300                       | 6.3 (13.8)                       |
| <b>1.6mm (1/16 in) DC+</b>          |                 |                                   |                    |                           |                                  |
| 100% CO <sub>2</sub>                | 20 (4/5)        | 5.8 (228)                         | 27-29              | 260                       | 5.1 (11.2)                       |
|                                     |                 | 7.9 (311)                         | 28-30              | 300                       | 5.9 (13.0)                       |
|                                     |                 | 9.7 (381)                         | 29-31              | 330                       | 7.4 (16.3)                       |

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX