

SC-420S

Martentic STS Type

Conformances

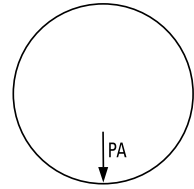
Applications

- 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	Coil			Pac		
	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)			
2.8 (7/64)	✓	✓	✓			
3.2 (1/8)	✓	✓	✓			

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr	Ni	Mo	Nb	V	W
As welded with 2.8/3.2mm wire	0.3	0.6	1.7	11.5	0.5	1.5	0.15	0.3	1.3

Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRC) (≥3layers)
On Mild Steel (2.8/3.2mm)	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)
3.2mm (1/8in), DC+					
Submerged Arc	25 (1)	1.4 (55)	350	28	3.9 (8.6)
		1.7 (66)	390	30	4.6 (10.1)
		1.8 (72)	430	31	5.3 (11.6)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX