HYUNDAI WELDING

Rev. 02

SC-55S

SUBMERGED ARC WIRE FOR THE HARDFACING OF STEEL MILL TABLE ROLL AS MARTENSITE ALLOY

HYUNDAI WELDING CO., LTD.

SC-55S

❖ Specification

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❖ Description & Applications

SC-55S is a submerged arc wire used for hardfacing and rebuilding components subject to metal-metal wear and moderate abrasion. (Crane Wheel, Rod Wheel, Tractor Roller, Steel mill rolls-required to get high hardness and abrasion resistance, etc.)

❖ Welding Process

SAW (with S-717 flux)

❖ Current Type

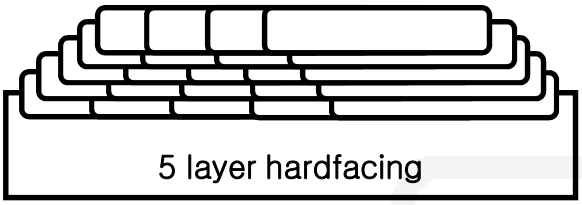
DC+

❖ Packing

SC-55S	**Dia.**	3.2mm(1/8in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	:	3.2mm(1/8in)
Welding Type	:	SAW(S-717)
Amp./ Volt.	:	400 / 30
Stick-Out	:	25~30mm(0.98~1.18in)
Pre-Heat℃	:	150~250℃(302~482°F)
Interpass Temp.	:	200~300℃(392~572°F)
Total layers	:	≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Mo	V	W
SC-55S	0.28	0.65	2.0	6.5	1.8	0.45	1.6

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
SC-55S	52	52	53	53	55	53

Test Results

❖ BEAD APPEARANCE

Consumable	SC-55S
Amp.(A)	380~400
Volt.(V)	28~30
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)