

SC-BU Cored

OPEN ARC WIRE FOR LOW ALLOY TYPE



SC-BU Cored

❖ Specification

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❖ Description & Applications

SC-BU is an open arc type wire. It is designed for the build-up mild and low alloy steels.

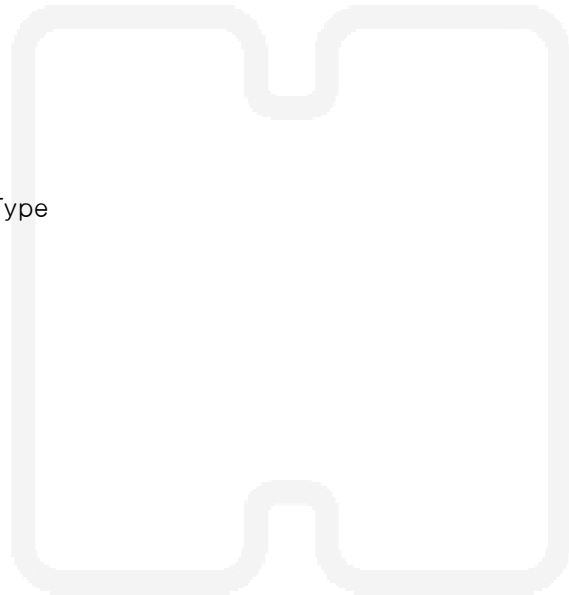
(Build-Up : Low Alloy type)

❖ Welding Process

Open Arc Type

❖ Current Type

DC+



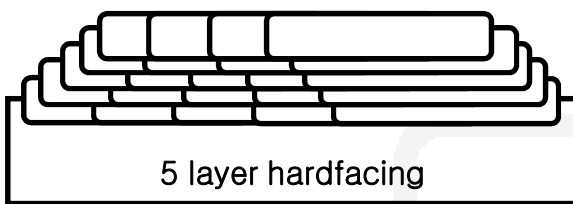
❖ Packing

SC-BU	Dia.	2.4mm(3/32in) 2.8mm(7/64in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



5 layer hardfacing

- Diameter** : 2.4mm(3/32in)
- Welding Type** : Open Arc
- Amp./ Volt.** : 380 / 28
- 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
SC-BU Cored	0.12	0.85	2.70	1.05

❖ Hardness test of All weld metal(HRc)

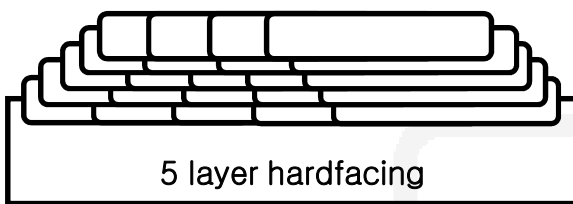
Consumable	Hardness(HRc)					Avg.
	27	27	29	30	30	
SC-BU Cored	27	27	29	30	30	28.5

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.8mm(7/64in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 29
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
SC-BU Cored	0.14	0.90	2.80	1.12

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
SC-BU Cored	28	30	30	30	32	30

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