SC-600HM

For Hard-facing

Conformances

DIN 8555 MSG 6-GF-60-P

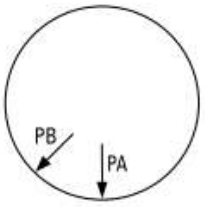
Applications

- Rollers, shear blades, screw conveyer etc.

Features

- Flat and horizontal fillet position welding
- Suitable for abrasion parts

Welding Position



Current

DC +

Shielding Gas

Ar + 20~25% CO_2
FCAW process

Diameter / Packaging

Diameter	Spool
mm (in)	15kg (33lbs)
1.2 (0.045)	√
1.6 (1/16)	√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.5	0.3	1.5	0.012	0.009	6.2	0.35

Typical Mechanical Properties of All-Weld Metal

Hardness (HRc)
58–62

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)
1.2mm (0.045 in) DC+					
80% Ar + 20% CO_2	20 (4/5)	9.8 (385)	230	25–27	4.5 (9.9)
		12.5 (492)	260	27–29	5.5 (12.1)
		14.2 (559)	300	29–31	6.4 (14.1)
1.6mm (1/16 in) DC+					
80% Ar + 20% CO_2	20 (4/5)	5.8 (228)	260	27–29	5.3 (11.6)
		7.9 (311)	300	28–30	6.2 (13.6)
		9.7 (381)	330	29–31	7.6 (16.7)

Caution	① Preheat the base metal for more than 150℃(302℉). ② Use Ar + 20-25% CO_2 mixed gas.
Purpose	① Rollers, shear blades, screw conveyer etc.
Attribute	① Flat and horizontal fillet position welding ② Suitable for abrasion parts.