

SC-30S

SUBMERGED ARC WIRE FOR LOW / MIDDLE ALLOY TYPE
METAL-METAL WEAR-RESISTANCE



❖ **Specification**

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❖ **Description & Applications**

SC-30S is a submerged arc wire used for hardfacing and rebuilding components subject to metal-metal wear and moderate abrasion. The weld deposit is typical of a low alloy steel. (Crane Wheel, Rod Wheel, Tractor Roller etc.)

❖ **Welding Process**

SAW (with S-717 flux)

❖ **Current Type**

DC+

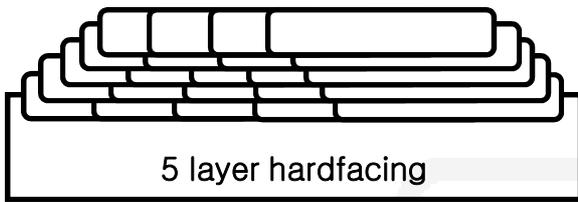
❖ **Packing**

SC-30S	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
SC-30S	1Layer	0.14	0.22	1.53	1.31	0.24
	2Layer	0.14	0.20	1.51	1.66	0.33
	Multi Layer	0.15	0.21	1.56	1.79	0.37

❖ Hardness test of All weld metal(HRc)

Consumable		Hardness(HRc)					Avg.
SC-30S	1 Layer	31	31	31	32	32	31.5
	2 Layer	30	31	33	34	34	32.5
	Multi Layer	33	33	34	35	36	34

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.



Test Results

❖ BEAD APPEARANCE

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



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