

# **SC-410NiMoS**

MARTENSITIC STS TYPE SUBMERGED ARC WIRE



## SC-410NiMoS

### ❖ Specification

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### ❖ Description & Applications

SC-410NiMoS is a submerged arc wire. Good at defect-resistance and weldability etc. by shielding weld metal with flux from defects.

(Steel Mill Rolls, Casting Rolls, etc.)

### ❖ Welding Process

SAW (with S-717 flux)

### ❖ Current Type

DC+

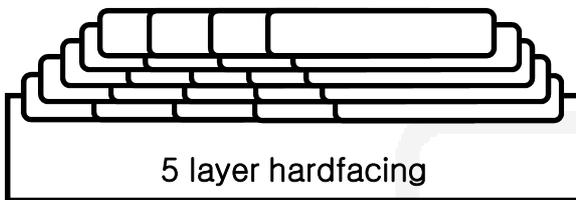
### ❖ Packing

SC-410NiMoS	<b>Dia.</b>	3.2mm(1/8in)
	<b>Coil</b>	25kg(55lbs)
	<b>Pailpack</b>	150kg(330lbs), 250kg(551lbs)



## Mechanical Properties & Chemical Composition of All Weld Metal

### ❖ Welding Conditions



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

### ❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Ni	Mo	Nb
SC-410NiMoS	0.06	0.80	1.83	13.9	4.80	0.59	0.25

### ❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
SC-410NiMoS	34	35	35	35	37	35



## Test Results

### ❖ BEAD APPEARANCE

<b>Consumable</b>	SC-410NiMoS
<b>Amp.(A)</b>	380~400
<b>Volt.(V)</b>	28~30
<b>Carrige Speed</b>	40~60cm/min(15.7~23.6in/min)
<b>Welding Position</b>	Flat(1G)



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.