

SC-250H

Features

- Designed for hardfacing FCAW with 100% CO2 gas
- Flat and horizontal fillet position welding
- Hardness of the weld metal : Over 250 Hv
- Suitable for metal to metal wear parts

Polarity

DC +

Application Areas

- Spindle, gear, shaft

Shielding Gas

100% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Wire size	C	Si	Mn	P	S	Cr	Mo
1.2(0.045)	0.06	0.5	1.2	0.01	0.01	1.1	0.01

Typical Mechanical Properties of All-Weld Metal

HRC (≥4Layers)
22~25

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
1.2(0.045)	230~300
1.6(1/16)	260~330

Diameter / Welding Parameters / Packaging

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

SMW

GMW

GTW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux