

SC-414S

Description & Applications

Good at defect-resistance and weldability etc. by shielding weld metal with flux from defects.
(Steel Mill Rolls, Casting Rolls)

Welding Process

SAW Type (with S-717, S-400HF Flux)

Current Type

DC +

Welding Position



1G
(PA)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	Nb	V
0.15	0.5	1.5	13.8	2.8	1.2	0.2	0.2

Hardness

HRc
40~45

Packaging Standard

Dia.(mm)	2.4/3.2
Coil(kg)	25
Pailpack(kg)	150, 250

SC-420S

Description & Applications

Good at defect-resistance and weldability etc. by shielding weld metal with flux from defects.
(Steel Mill Rolls, Casting Rolls)

Welding Process

SAW Type (with S-717, S-400HF Flux)

Current Type

DC +

Welding Position



1G
(PA)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	Cr	Ni	Mo	Nb	W	V
0.3	0.7	1.8	12.2	0.5	1.6	0.15	1.4	0.2

Hardness

HRc
48~52

Packaging Standard

Dia.(mm)	2.8/3.2
Coil(kg)	25
Pailpack(kg)	150, 250