

SC-48S

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



❖ Specification

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❖ Description & Applications

SC-48S is a submerged arc wire used for hardfacing and rebuilding components subject to metal-metal wear and moderate abrasion. The weld deposit is a medium alloy steel that is a hard, tough Martensitic. (Crane Wheel, Rod Wheel, Tractor Roller, Steel mill rolls etc.)

❖ Welding Process

SAW (with S-717 flux)

❖ Current Type

DC+

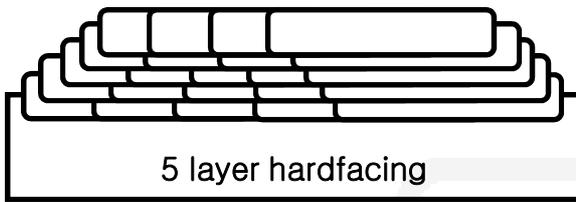
❖ Packing

SC-48S	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 °C	: 150~250°C (302~482°F)
Interpass Temp.	: 200~300°C (392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr	Mo	V
SC-48S	0.25	0.83	2.51	6.02	0.63	0.31

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
SC-48S	46	46	48	48	50	48



Test Results

❖ BEAD APPEARANCE

Consumable	SC-48S
Amp.(A)	380~400
Volt.(V)	28~30
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	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.