S-402HF

Flux Properties

Class. EN ISO 14174 S A AB 2
Current AC, DC +
Density 1.1g/cm^3
BI 2.5
Grain Size 10 x 48 Mesh

Features

- Outstanding weldability, Good slag removal.
- Hardfacing welding

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

Wire	C	Si	Mn	Ni	Cr	Mo	Nb	W	V
SC-414S	0.10	0.6	1.2	2.6	14.8	1.0	0.20	-	0.4
SC-423S	0.05	0.4	1.0	2.5	16.7	1.2	0.20	-	0.4
SC-420S	0.33	0.8	1.8	0.5	12.6	1.9	0.18	1.4	0.4
SC-420SG	0.29	0.6	1.5	0.2	13.9	-	0.17	-	-
SC-430S	0.06	0.7	1.1	-	17.4	-	-	-	-
SC-423S(B)	0.08	0.8	1.2	3.7	19.9	1.4	0.14	-	0.3
SC-414S(B)	0.08	0.5	1.8	2.7	12.3	0.4	0.13	-	0.3
SC-423S(N)	0.07	0.8	1.5	4.6	19.3	2.5	0.23	-	0.3
SC-414S(N)	0.11	0.6	1.5	2.6	14.9	1.1	0.18	-	0.3

Typical Mechanical Properties of All-Weld Metal

Wire	Hardness (HRC)
SC-414S	43~47
SC-423S	-
SC-420S	50~55
SC-420SG	50~55
SC-430S	-
SC-423S(B)	-
SC-414S(B)	43~47
SC-423S(N)	-
SC-414S(N)	43~47

Wire Diameter & Packaging

Packaging
Tin Can 20kg (44lbs) PE Bag 20kg (44lbs)