

# SFH-61GM

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-61GM is a gas shielded metal mold hard welding wire, which deposited metal and contains special alloys, and has excellent wear resistance.
- It is suitable for hard surface welding of bulldozer blades, bucket lips, dumping teeth and propeller components subject to severe soil friction.

### NOTE ON USAGE :

- Preheating and interlayer temperature need to exceed 300 °C.
- Using CO<sub>2</sub> as protective gas, the purity of CO<sub>2</sub> gas is over 99.8%, and the flow rate is 15 ~ 25 l/min.

### Typical Chemical Composition Of Weld Metal (wt%) :

C	Mn	Si	Cr	Nb	W	B
2.93	0.72	1.12	25.70	0.19	0.25	0.18

### HARDNESS :

Layers	1 <sup>st</sup> layer	2 <sup>nd</sup> layer	3 <sup>rd</sup> layer
Hardness (HRC)	57	59	61

### SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter ( mm )	Voltage (V)
1.2	25-36
1.6	25-35
Current (A)	Gas flow (l/min)
200-300	15-25
250-400	15-25

# SFH-61NbGM

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-61NbGM is a gas shielded metal mold hard flux welding wire, which has excellent wear resistance at high temperature due to its niobium (Nb) content.
- It is suitable for hard surface welding of bulldozer blades, bucket lips, dumping teeth and propeller components subject to severe soil friction.

### NOTE ON USAGE :

- Preheating and interlayer temperature need to exceed 300 °C.
- Using CO<sub>2</sub> as protective gas, the purity of CO<sub>2</sub> gas is over 99.8%, and the flow rate is 15 ~ 25 l/min.

### Typical Chemical Composition Of Weld Metal (wt%) :

C	Mn	Si	Cr	Nb
5.34	0.59	1.56	21.24	2.49

### HARDNESS :

Layers	1 <sup>st</sup> layer	2 <sup>nd</sup> layer	3 <sup>rd</sup> layer
Hardness (HRC)	59	61	63

### Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
1.2	25-36
1.6	25-35
Current (A)	Gas flow (l/min)
200-300	15-25
250-400	15-25