

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-22S is used for submerged arc welding, and the molten gold obtained by matching SF-82 alkaline welding flux is ferrous iron structure.
- Molten gold itself has good cracking resistance and tempering softening resistance, as well as good pitting corrosion resistance. It can be used for buffer layers (S45C, SUJ2 ..., etc.) of base metal with high carbon content, and welding slag is easy to peel off. It is suitable for multi-layer welding and welding of small diameter rollers. After welding, it can also be machined.
- Its applications include backing and heap welding of rollers in iron and steel plants, repair and regeneration of roller shaft tail, buffer layer of high carbon base metal, and hard surface repair of crown wheels, rolling wheels, idler wheels and mining wheels.

NOTE ON USAGE :

- When the surface curvature of the workpiece is too large, the thickness is too thick or the shape is too complex, the weld bead after welding is easy to produce high internal stress Force, causing cracking after welding, so preheating at 350 ~ 400°C and interlayer temperature are required, and slow cooling is recommended after welding Handle.
- When the stress relief annealing temperature exceeds 480°C, the hardness of molten gold will decrease.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr	Mo
0.09	1.99	0.60	1.00	2.00

HARDNESS :

Layers	2 nd layer	3 rd layer
Hardness (HRC)	29~33	30~34

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	Voltage (V)	Current (A)	Stickout (mm)
3.2	28-32	350-450	25-40