

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-31S submerged arc welding uses hard flux welding wire with SF-80 alkaline flux.
- The molten gold is low carbon and low alloy Matian loose iron structure, which can be machined, forged and hardened after welding.
- It is used for backing before repairing the hard surface of roller wheel, idler wheel, trunnion or plate, or for welding and repairing the final cover of rails, shafts and journals with medium hardness and requiring machining.

NOTE ON USAGE :

- Before welding, remove the dust, grease and moisture on the surface of the base metal.
- Please use DC (+) polarity when welding, and AC polarity can be used in some special automatic occasions.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Mo
0.10	2.10	0.40	0.30

HARDNESS :

Layers	1 st layer	2 nd layer	3 rd layer
Hardness (HRC)	16	24	28

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	Voltage (V)	Current (A)	Stickout (mm)
2.8	23-28	220-350	25-30
3.2	28-32	350-450	25-30