

# SFH-35G

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-35G is a gas shielded hard bread welding wire, which can be used as a hard surface welding material for general wear resistance consumption.
- It is suitable for transmission gears, idlers, pulleys, crawlers, gravel rollers, mud shovels, mud buckets, chains, axles and other parts.

### NOTE ON USAGE :

- 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	Mo
0.20	1.90	0.72	1.70	0.53

### HARDNESS :

Layers	2 <sup>nd</sup> layer	3 <sup>rd</sup> layer	4 <sup>th</sup> layer
Hardness (HRC)	32	36	39

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-42MG

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-42MG is a gas-shielded hard welding wire with 13% Cr-1% Mo in dissolved gold.
- It is suitable for corrosion-resistant and soil-resistant applications, such as mixing propellers, stamping dies, digging shovels, valve seats, bulldozer components, turbine blades, and hard-faced welding of conveying spirals.

### NOTE ON USAGE :

- It is suggested that the preheating and interlayer temperature should exceed 200 °C and be cooled to room temperature after welding.
- 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	Mo
0.28	0.42	0.43	12.61	0.75

### HARDNESS :

Layers	4 <sup>th</sup> layer
Hardness (HRC)	52-56

Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
1.2	25-32
1.6	28-38
Current (A)	Gas flow (l/min)
150-300	15-25
200-400	15-25