

## SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-42S is a hard flux welding wire for submerged arc welding of stainless steel Matian loose iron structure, which is matched with SF-80 alkaline welding flux.
- The welder has good crack resistance, and the welding slag is easy to peel off, and the number of layers is unlimited.
- It is suitable for regeneration and repair of continuous casting roller wheel, blast furnace coal cover, printing roller steel wheel, trunnion and other workpieces.

### NOTE ON USAGE :

- When the carbon content of the base metal reaches 0.8% or the carbon content of the low alloy steel exceeds 0.35%, the base metal is preheated to 300-400°C.
- 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.
- It causes cracking after welding, so preheating at 200 ~ 420°C and interlayer temperature are required. Slow cooling treatment is recommended after welding.

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.22	1.42	0.53	13.0

### HARDNESS :

Layers	1 <sup>st</sup> layer	2 <sup>nd</sup> layer	3 <sup>rd</sup> layer
Hardness (HRC)	43	46	49

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

Diameter ( mm )	Voltage (V)	Current (A)	Stickout (mm)
2.8	26-32	220-350	25-30
3.2	28-32	350-450	25-30