

SFH-45G

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-45G is a gas shielded hard bread welding wire.
- It is suitable for transmission gears, idlers, pulleys, crawlers, gravel rollers, mud shovels, mud buckets, chains, axles and other parts.

NOTE ON USAGE :

- Preheating and interlayer temperature need to exceed 300 °C.
- Using CO₂ as protective gas, the purity of CO₂ 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
0.30	1.90	0.70	3.00

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	42	46	50

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-50G

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-50G is a gas shielded hard bread welding wire.
- 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 CO₂ as protective gas, the purity of CO₂ 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	Ti
0.26	1.83	0.52	6.21	0.52	0.14

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	49	52	54

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