

FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-51-O self-shielding hard bread welding wire fused gold is high carbon Votian iron and eutectic structure, with high hardness and excellent wear resistance.
- Suitable occasions include coal grinding wheel, coal shovel, dredger cutter, coal rolling tooth and many other hard surface welding workpieces.

NOTE ON USAGE :

- After welding, the molten gold cannot be machined and can only be ground with grinding wheels.
- If the workpiece is carbon steel, low alloy steel or cast iron, it should be preheated to 200 °C, or the transition layer should be made before hard surface heap welding.

Typical Chemical Composition Of Weld Metal (wt%):

C	Mn	Si	Cr
3.23	1.26	1.57	13.18

HARDNESS :

Layers	1 st layer	2 nd layer
Hardness (HRC)	54-58	55-60

Size And Recommended Current Range : DC(+)

Diameter (mm)	Voltage (V)
2.8	27-30
Current (A)	Stickout (mm)
250-400	50-70