

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-53S is a hard bread flux welding wire for submerged arc welding, which is matched with SF-80 alkaline welding flux. Its dissolved gold is Matian loose iron structure.
- Molten gold itself has excellent adhesion wear resistance and weld mark resistance, and can still maintain good high temperature red heat hardness at high temperature.
- Its applications include rollers in iron and steel mills and other occasions that generally need to bear sliding wear between metals.

NOTE ON USAGE :

- The preheating temperature during welding is 200 ~ 250°C, and the interlayer temperature is controlled at 300 ~ 400°C.
- To avoid cracking, the workpiece should be slowly cooled and heat treated after welding.
- When the weldability of the base metal is poor, it is recommended to use a layer of SF-65/SW-M12K as the buffer layer first, and then use SFH-31S/SF-80 or SFH-22S/SF-82 as the backing according to the actual welding layer thickness requirements.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Ni	Cr	Mo	V
0.20	2.07	0.50	3.2	6.61	1.84	0.45

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	47	49	50

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	Voltage (V)	Current (A)	Stickout (mm)
3.2	28-32	350-450	25-40