

SFH-55G

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-55G 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
0.42	0.70	2.30	8.00	0.62	0.14

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	52	54	55

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-58G

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-58G is a gas shielded hard bread welding wire. Its dissolved gold has high hardness and is superior in wear resistance due to its tungsten (W) content.
- 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	W
0.50	0.58	0.90	8.0	0.5

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	55	56	58

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