

SFH-58GM

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-58GM is a gas shielded metal mold hard bread flux welding wire. Its dissolved gold has high hardness and excellent wear resistance at normal temperature.
- 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 :

- The rust layer, moisture, oil stain, dust, etc. of the welded part shall be removed.
- 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
0.60	1.18	0.70	6.00	0.60

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	55	56	59

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

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-59G is a gas shielded hard bread welding wire. Its dissolved gold contains special metals, so its wear performance is excellent.
- 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	Ti	B
0.70	0.98	0.68	8.50	0.22	0.38

HARDNESS :

Layers	2 nd layer	3 rd layer	4 th layer
Hardness (HRC)	57	60	63

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