

SFH-62GM

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-62GM is a gas shielded metal mold hard flux welding wire. Its dissolved gold contains high chromium alloy and has excellent wear performance.
- 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	Ni	V	B
3.8	0.66	1.00	25.50	0.17	0.08	0.30

HARDNESS :

Layers	1 st layer	2 nd layer	3 rd layer
Hardness (HRC)	58	60	64

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-63G is a chemical-coated welding wire for gas shielding hard surface. Its dissolved gold has high hardness and excellent wear property.
- 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	B
0.71	0.95	0.59	7.81	0.38

HARDNESS :

Layers	1 st layer	2 nd layer	3 rd layer
Hardness (HRC)	59	61	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