

FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-66WG is a gas shielded hard welding wire. Its dissolved gold contains special alloys such as niobium, vanadium and tungsten, so it has high wear resistance.
- 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	Mo	Nb	V	W
4.91	0.41	1.78	21.44	0.11	0.38	2.61	0.34	2.45

HARDNESS :

Layers	1 st layer	2 nd layer	3 rd layer
Hardness (HRC)	60	63	63.5

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)	Voltage (V)	Current (A)	Gas flow (l/min)
1.2	25-36	200-300	15-25
1.6	25-35	250-400	15-25