

# SFH-67-O

AWS –  
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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-67-O is a self-shielding hard bread welding wire containing chromium carbide and boride precipitation.
- There are usually stress release cracks in welding beams, and the hardness of dissolved gold after welding is extremely high, which cannot be machined by machining, but only grinding wheels can be used for grinding.
- Applicable occasions are hard surface repair with high wear and low impact, such as coal roller, ghost tooth, receiving tooth, blast coal cover, grinder parts, etc.

### NOTE ON USAGE :

- For hard surface welding of high carbon steel or low alloy steel, Austenite iron stainless steel welding material can be used as backing transition layer.
- It is suggested that the number of welding layers should be controlled within 2 to avoid peeling off the welding layer.

### Typical Chemical Composition Of Weld Metal (wt%):

C	Mn	Si	Cr	B
5.24	0.46	0.67	36.74	1.62

### HARDNESS :

Hardness (HRC)	63-66
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### Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
2.8	26-32
Current (A)	
250-400	

# SFH-70-O

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-70-O is a self-shielding hard bread welding wire containing chromium carbide and boride precipitation.
- There are usually stress release cracks in welding beads, and the hardness of molten gold after welding is extremely high, which cannot be machined and can only be ground by grinding wheels.
- Applicable occasions are hard surface repair with high wear and low impact, such as coal roller, ghost tooth, receiving tooth, blast coal cover, grinder parts, etc.

### NOTE ON USAGE :

- For hard surface welding of high carbon steel or low alloy steel, Austenite iron stainless steel welding material can be used as backing transition layer.
- It is suggested that the number of welding layers should be controlled within 2 layers to avoid peeling off the welding layer.

### Typical Chemical Composition Of Weld Metal (wt%):

C	Mn	Si	Cr	B
5.43	0.60	0.50	28.9	0.35

### HARDNESS :

Hardness (HRC) 2 <sup>nd</sup> layer	64-68
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### Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
2.8	26-32
Current (A)	
250-400	