

# SFH-67NMG

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-67NMG is a gas shielded hard bread welding wire containing high chromium and high carbon structure, which has excellent resistance to strong soil and sand wear and high temperature wear.
- Applicable occasions for liner, spiral impeller, crusher parts and other hard surface repair.

### NOTE ON USAGE :

- No matter whether it is preheated or post-heat treated, cracks are easy to occur, so multi-layer heap welding is not suitable.

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

C	Mn	Si	Cr	Mo	Nb
6.02	0.39	2.05	22.68	1.75	2.74

### HARDNESS :

4 <sup>th</sup> layer Hardness (HRC)	65-68
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### Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
1.2	28-32
1.6	34-38
Current (A)	
250-280	
320-370	

# SFH-MN-O

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-MN-O is a work hardening self-shielding welding wire with excellent crack resistance.
- It has high work hardening property and good strength and toughness, and is suitable for heavy impact wear.
- It is suitable for heap welding of crusher cone body, crusher punching, etc., or transition layer.

### NOTE ON USAGE :

- The welding of base metal 13Mn steel does not need preheating, and low current should be used to prevent the base metal from overheating.

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

C	Mn	Si	Cr	Ni
0.22	17.05	0.35	18.4	1.00

### HARDNESS :

Hardness	18~22
Hardness after work hardening (HRC)	44~48

### Size And Recommended Current Range : DC(+)

Diameter ( mm )	Voltage (V)
2.8	27-30
Current (A)	Stickout (mm)
250-400	50-70