

# SFH-MNG

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-MNG is a gas-shielded work-hardening hard bread 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. and nest burying repair welding of 13Mn cast steel.

### NOTE ON USAGE :

- The rust layer, moisture, oil stain, dust, etc. of the welded part shall be removed.
- The welding of base metal 13Mn steel does not need preheating, and low current should be used to prevent the base metal from overheating.
- Using CO<sub>2</sub> as protective gas, the purity of CO<sub>2</sub> gas is over 99.8%, and the flow rate is 15 ~ 25 l/min.

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

C	Mn	Si	Ni
0.71	12.75	0.20	4.0

### HARDNESS :

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

### 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

# SFH-25G

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-25G is a gas shielded hard bread welding wire, which can be used as a hard surface welding material for backing or general abrasion.
- It is suitable for transmission gears, idlers, pulleys, crawlers, gravel rollers, mud shovels, mud buckets, chains, axles and other parts.

### NOTE ON USAGE :

- Using CO<sub>2</sub> as protective gas, the purity of CO<sub>2</sub> 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
0.121	1.73	0.68	1.18	0.45

### HARDNESS :

Layers	2 <sup>nd</sup> layer	3 <sup>rd</sup> layer	4 <sup>th</sup> layer
Hardness (HRC)	22	23	25

### 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