

SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-26R is a titanium ore series electric welding rod, and the filler metal group is Bolai iron, which is easy to be machined by mechanical cutting.
- It is good to restart arc during welding, and is suitable for light wear between runner, sprocket, axle center, gear and wheel metal.

NOTE ON USAGE :

- Before welding, the weld shall be dried at 120 °C for 60 minutes. When in use, a small amount shall be taken out and put into a heat preservation drying cylinder. The maximum amount of weld carried out shall be the same day.
- For multi-layer heap welding of low alloy steel or high carbon steel, the base metal should be preheated above 150°C first.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.21	0.48	0.53	1.42

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 °C under	300	30	42
pile up welding	270	26	38

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)	3.2	4.0	5.0	5.0
Length (mm)	350	400	400	350
Current (Amp)	70-120	110-170	160-220	130-170