

SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-35R is a titanium ore series electric welding rod, which has good arc restarting performance during welding.
- It can be machined and can resist impact and light wear.
- It is suitable for welding and mending transmission gears, idlers, pulleys, crawlers, gravel rollers, mud shovels, mud buckets, chains, axles and other parts.

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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.3	0.45	0.40	1.90

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 °C under	355	36	48
pile up welding	280	27	40

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

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