

SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-45 is a low-hydrogen electric welder, and the structure of the filler metal is fertilizer grain iron plus snow carbon iron.
- It is suitable for transmission gears, idlers, pulleys, crawlers, gravel rollers, mud shovels, mud buckets, chains, axles and other parts.

NOTE ON USAGE :

- Before welding, the weld should be dried at 300 ~ 350°C for 30 ~ 60 minutes. When in use, a small amount should be taken out and put into a drying cylinder at 100 ~ 150°C. The maximum amount of weld carried out should be the same day.
- It is suggested to preheat the base metal above 150 °C first.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.2	2.1	0.55	2.90

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 °C under	450	45	61
pile up welding	380	39	52
900° C water quenching	470	47	63

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