

## SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SH-58HC is a low-hydrogen electric welder, and the dissolved gold is a primary carbide and eutectic structure.
- The content of chromium carbide is high, and the hardness has little downward trend at high temperature, so the high temperature wear resistance and corrosion resistance are excellent.
- Suitable for mixing blades, cutters, sievers, etc.

### 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.
- The base metal is preheated at a temperature above 400 °C.
- It is preferable that the number of welded layers should not exceed 2 or 3 layers.

### WELDING POSITION :



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
3.7	1.35	0.69	34.77

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 °C under	680	59	80
pile up welding	660	58	79

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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Current (Amp)	90-140	140-180	190-220