

## SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SH-60 is a low-hydrogen electric welder, and the filler metal structure is Martenite loose iron.
- It is a self-hardening wear-resistant welder, which has good effect on moderate impact and wear, and is difficult to cut mechanically.
- It is suitable for welding and repairing the wear between metal contact surfaces such as wheel chain, stone crusher, connecting ring, bucket, gravel plate, earth stacker, earth stacker, vehicle guide, shovel tooth, crawler, pump barrel, blade, etc.

### NOTE ON USAGE :

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

### WELDING POSITION :



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

C	Mn	Si	Cr
0.31	1.20	0.29	3.0

### 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
600 ° C water quenching	355	36	49

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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Current (Amp)	80-120	120-170	160-210