

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-80B is a low hydrogen electric welder with self-hardening Matian loose iron structure.
- It is most suitable for repairing and heap welding of mechanical parts with high wear resistance requirements, and has excellent workability and welding slag peeling property, Machining is difficult.
- It is suitable for welding repair of medium carbon steel, low alloy, sand wear, pump barrel blades, stirring blades, 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 200°C.
- In multi-layer heap welding, the hardening property is higher than that of the base metal, so it is advisable to use low hydrogen electric welding rod for bottom welding first.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr	B
1.29	1.11	0.99	6.99	0.29

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temprature 150 ° C under	660	58	79
pile up welding	620	56	75

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