

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-95HN is a low hydrogen electric welding rod, and the dissolved gold component contains chromium (Cr), niobium (Nb), molybdenum (Mo), tungsten (W), vanadium (V) and other elements.
- Excellent wear resistance at high temperature and excellent wear resistance in high temperature corrosion environment, suitable for sandblasting nozzle, pump body, pump vane, combustion nozzle, 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 250°C.
- Avoid spalling of molten gold during multi-layer welding, and it is better to weld with cross hollow lattice.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr	Mo	Nb	W	V
5.37	1.28	2.41	21.5	4.74	6.47	1.81	0.9

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition		Vicker's (HV)		Rockwell's (HRC)		Shores's (HS)	
Layer temperature 150°C under		800		64		88	
pile up welding		700		60		81	
High temperature hardness	Temperature (°C)	300	400	500	600	-	
	Vicker's (HV)	730	650	580	460	-	

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