SH-WM

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SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-WM is a low-hydrogen electric welding rod, and the dissolved gold component contains molybdenum (Mo) and tungsten (W) elements.
- The tungsten carbide structure with high hardness is produced, which has excellent wear resistance. Its composition contains molybdenum (Mo), which can increase its toughness and prevent cracking due to segregation of tungsten carbide.
- Suitable for cutters, bucket teeth, stirring spiral blades, scrapers, 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 300°C.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Mo	W
2.50	1.3	1.10	3.50	35.5

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temprature150°Cunder	750	62	85

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