SFH-42MG  
AWS  --  
JIS  --  
EN  --  

FLUX CORED WIRES FOR HARDFACING

DESCRIPTION:
SFH-42MG is a gas-shielded flux cored wire with 13%Cr-1%Mo in its deposited weld. It suits for the purpose of hardfacing in anti-abrasion conditions as well as the case with the requirement of corrosion resistance meanwhile.

APPLICATIONS:
SFH-42MG is aimed at the hardfacing of tipper teeth, bucket lip, bulldozer shovel blade, and the parts of impellers employed for soil abrasion or erosive wear.

NOTE ON USAGE:
1. Proper preheat and interpass temperatures shall be kept over 200°C and the cooling rate shall be kept low after welding.
2. Use CO2 Gas 99.8% and keep flow rate 15~25 l/min
3. Welding parts is required to be clean from dust, oil and rusty

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.22
Manganese (Mn) 0.42
Silicon (Si) 0.43
Chromium (Cr) 12.61
Molybdenum (Mo) 0.91

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>Layer</th>
<th>4th layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC</td>
<td>50 ~ 52</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2 mm</th>
<th>1.6 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>25 ~ 32</td>
<td>28 ~ 38</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>150 ~ 300</td>
<td>200 ~ 400</td>
<td></td>
</tr>
<tr>
<td>Flow Rate(l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
</tr>
</tbody>
</table>