DESCRIPTION:
SFH-42S is a submerged arc flux cored wire with stainless steel martensite structure. It produces excellent crack resistance, and slag detachability is good, and suitable for multi layers build-up.

APPLICATIONS:
It is used for maintenance steel mill rollers, continuous casting rollers, printing rollers etc.

NOTE ON USAGE:
1. Use DC (+) polarity
2. The preheat and interpass temperatures at 300~400°C for base metal carbon content of 0.8% or low alloy steel carbon content more than 0.35%
3. Application recommendations for high thickness, big angle curvature of workpiece surface to avoid cracks.
   *Preheat and interpass temperatures 200~400°C
   *Control low cooling speed.
4. Recommended flux SF-80

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.22
Manganese (Mn) 1.42
Silicon (Si) 0.53
Chromium (Cr) 12.7

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>Layer</th>
<th>1st layer</th>
<th>2nd layer</th>
<th>3rd layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC</td>
<td>43</td>
<td>46</td>
<td>49</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <+>):

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>2.8mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 32</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>350 ~ 450</td>
<td></td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>25 ~ 40</td>
<td></td>
</tr>
</tbody>
</table>