DESCRIPTION:
SFH-53S is a submerged arc flux cored wire for hardfacing, provides martensitic structure with SF-80 basic flux. Deposit carries excellent resistance to extreme abrasive wear, hardness at high temperature.

APPLICATIONS:
It is used for build-up pinch rollers, cc rollers, and surfacing subject to sliding metal to metal wears.

NOTE ON USAGE:
1. Recommended preheat temperature at 200~250°C; interpass temperature at 300~400°C.
2. Slow down the cooling speed after weld before heat treatment.
3. To apply with SF-65/SW-M12K as buffer layer followed root-pass layer by SFH-31S/SF-80 or SFH-22S/SF-82

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.23
Manganese (Mn) 2.07
Silicon (Si) 0.45
Molybdenum (Mo) 1.84
Nickel (Ni) 3.20
Chromium (Cr) 6.61
Vanadium (V) 0.45

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>50</td>
<td>51</td>
<td>52</td>
</tr>
</tbody>
</table>

APPROVALS:
-

SUGGESTED WELDING PARAMETERS (DC <->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>3.2mm</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>E.S.O.(mm)</td>
<td>25 ~ 40</td>
<td></td>
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</tbody>
</table>