DESCRIPTION:
SFH-55S is a submerged arc flux cored wire with basic type flux, SF-80 contains of Ni, Cr etc. The deposit metal can provide superior abrasive wear resistance, and maintain good hardness at high working tempature.

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

NOTE ON USAGE:
1. Use DC (+) polarity
2. Recommended preheat temperature at 200-250°C, interpass temperature at 300-400°C
4. PWHT parameters recommedned: 520°C x 6hr. (100°C/hr to increase; 50°C/hr to reduce to 300°C, then move from oven for air cooling
5. To apply with SF-65/SW-M12K as buffer layer followed root-pass layer by SFH-31S/SF-80

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.19
Manganese (Mn) 1.97
Silicon (Si) 0.54
Molybdenum (Mo) 1.25
Nickel (Ni) 3.10
Chromium (Cr) 3.85
Vanadium (V) 0.35

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>Layer</th>
<th>3rd layer</th>
<th>4th layer</th>
<th>5th layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC</td>
<td>52</td>
<td>49</td>
<td>51</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <+>):

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>3.2mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volts)</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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</table>