DESCRIPTION:
SFH-56-O is an open arc flux cored wire whose hardness of its weld metal is around HRC 56 providing excellent abrasion and resistance. It can rise HRC about three degree by work-hardened.

APPLICATIONS:
It is used for the repair of pulverizer rings, bucket and dipper teeth. Preheat shall be done while the deposition is over two layers.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Proper preheat and interpass temperatures between 150~250°C.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.48
Manganese (Mn) 1.25
Silicon (Si) 0.68
Chromium (Cr) 6.23
Molybdenum (Mo) 0.85

TYPICAL HARDNESS OF WELD METAL:
| HRC  | 52 ~ 60 |

SUGGESTED WELDING PARAMETERS (DC <+->)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>27 ~ 30</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 400</td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>50 ~ 70</td>
</tr>
</tbody>
</table>