SFH-59G

DESCRIPTION:
SFH-59G is a gas-shielded flux cored wire with great performance of stable arc, resistant to blow-hole and smooth welding bead. It is suitable for wide range of welding parameter, it can obtain the good resistance of weld metal for repair and hardness.

APPLICATIONS:
SFH-59G is aimed at the hardfacing of tipper teeth, bucket lip, bulldozer blade, and the parts of impellers employed for soil abrasion.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Proper preheat and interpass temperatures shall be kept over 300°C.
3. Use CO2 99.8% as a shielding gas and 15~25 l/min flow rate
4. Welding parts is required to be clean from dust, oil and rusty

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 0.65
Manganese (Mn) 0.98
Silicon (Si) 0.68
Chromium (Cr) 8.21
Titanium (Ti) 0.22
Boron (B) 0.29

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>Layer</th>
<th>2nd layer</th>
<th>3rd layer</th>
<th>4th layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>HRC</td>
<td>57</td>
<td>59</td>
<td>60</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></td>
<td>25 ~ 36</td>
<td>25 ~ 35</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>200 ~ 300</td>
<td>250 ~ 400</td>
</tr>
<tr>
<td>Flow Rate(l / min)</td>
<td></td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
</tr>
</tbody>
</table>