DESCRIPTION:  
SFH-61GM is a gas-shielded metal cored wire whose deposit hardness could reach around HRC60. Its weld metal contains carbide forming ingredients, such as Cr, Nb for providing great resistance to severe abrasion wear. Good bead appearance and stable arc could be obtained.

APPLICATIONS:  
SFH-61GM has a great resistant abrasion for repairing bucket, pulverizer rings and dipper teeth.

NOTE ON USAGE:  
1. Use DC (+) polarity.  
2. Proper preheat and interpass temperatures shall be kept over 300°C.  
3. CO2 as a shielding gas and 15~25 l/min for gas flow  
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) 2.93  
Manganese (Mn) 0.72  
Silicon (Si) 1.12  
Chromium (Cr) 25.13  
Nickel (Ni) 0.14  
Niobium (Nb) 0.19  
Wolfram (W) 0.29  
Boron (B) 0.15

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>57</td>
<td>59</td>
<td>61</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
<th>1.6mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>25 ~ 36</td>
<td>25 ~ 35</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>200 ~ 300</td>
<td>250 ~ 400</td>
<td></td>
</tr>
<tr>
<td>Stickout (mm)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
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</tbody>
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