DESCRIPTION:
SFH-62GM is a gas-shielded flux cored wire with great performance of stable arc, resistant to blowhole and smooth welding bead. With usage of wide range of welding parameter, it can obtain the good wear resistance of weld metal for hardfacing.

APPLICATIONS:
SFH-62GM is used for the hardfacing of tipper teeth, bucket lip, bulldozer shovel 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 99.8% CO2 Gas and keep flow rate 15~25 l/min
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) 2.32
Manganese (Mn) 0.66
Silicon (Si) 0.71
Chromium (Cr) 23.98
Nickel (Ni) 0.17
Vanadium (V) 0.11
Boron (B) 0.41

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>58</td>
<td>59</td>
<td>62</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>