DESCRIPTION:
SFH-65-O is a self-shielded flux cored wire that deposits a primary chromium-carbide surfacing alloy.

APPLICATIONS:
It can be used on components subject to severe abrasion with low or moderate impact i.e. slag ladies conveyor, pipe bends ball, mill scoop lips, teeth, crushing mills

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Remove the old surface build up layer of workpiece before welding
3. PWHT on weld metal is NOT recommended
4. Only sand grinding wheel machine is recommended.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
Carbon (C) 4.86
Manganese (Mn) 0.57
Silicon (Si) 0.84
Chromium (Cr) 23.30
Molybdenum (Mo) 5.32
Tungsten (W) 1.12
Niobium (Nb) 5.23
Vanadium (V) 1.12

TYPICAL HARDNESS OF WELD METAL:

<table>
<thead>
<tr>
<th>HRC</th>
<th>Room temp.</th>
<th>At 600°C</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>62 ~ 65</td>
<td>52 ~ 56</td>
</tr>
</tbody>
</table>

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>2.8mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>27 ~ 32</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 400</td>
<td></td>
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<tr>
<td>Stickout (mm)</td>
<td>50 ~ 70</td>
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