DESCRIPTION:
SFH-66WG is a gas-shielded flux cored wire with great performance of stable arc, blowhole resistance and smooth bead appearance. Deposited metal gives high hardness and good resistance for hardfacing.

APPLICATIONS:
SFH-66WG is designed for hardfacing of tippr 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. 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) 4.91
Manganese (Mn) 0.41
Silicon (Si) 1.78
Chromium (Cr) 21.44
Nickel (Ni) 0.11
Molybdenum (Mo) 0.38
Niobium (Nb) 2.61
Vanadium (V) 0.34
Tungsten (W) 2.45

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>60</td>
<td>63</td>
<td>64</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>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>Flow Rate(l / min)</td>
<td>15 ~ 25</td>
<td>15 ~ 25</td>
<td></td>
</tr>
</tbody>
</table>