DESCRIPTION:
SFH-67-O is a self-shielded flux cored wire that contains ledeburitic structure with a great amount of embedded chromium carbides.

APPLICATIONS:
It is designed for the components subject to severe abrasion with low or moderate impact i.e. bucket teeth, coke oven screen, shovel, blast furance bell.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. To use austenite stainless steel for build-up layer onto high carbon steel or low alloy steel.
3. It is recommended to apply bead of rib or waffle pattern in case of multi layer welding.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
- Carbon (C) 5.24
- Manganese (Mn) 0.46
- Silicon (Si) 0.67
- Chromium (Cr) 36.74
- Boron (B) 1.62

TYPICAL HARDNESS OF WELD METAL:
- HRC 63 ~ 66

SUGGESTED WELDING PARAMETERS (DC <+>):

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
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<tbody>
<tr>
<td>Voltage (Volt)</td>
<td>26 ~ 32</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 400</td>
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</tbody>
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