SFH-67NMG is a gas-shielded flux cored with high content of chromium carbide in the deposit, providing superior performance of earth abrasion and wear resistance even at high working temperature.

APPLICATIONS:
SFH-67NMG is used for liner, helical impeller, crusher parts, etc.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Not recommended for multi-layer build-up welding, because crack occurs no matter preheat/PWHT treatments.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
Weld Metal Analysis:
- Carbon (C): 6.02
- Manganese (Mn): 0.39
- Silicon (Si): 2.05
- Chromium (Cr): 22.68
- Molybdenum (Mo): 1.75
- Niobium (Nb): 2.74

TYPICAL HARDNESS OF WELD METAL:
- Layer: 4th layer
- HRC: 65 ~ 68

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>28 ~ 32</td>
<td>34 ~ 38</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>250 ~ 280</td>
<td>320 ~ 370</td>
<td></td>
</tr>
</tbody>
</table>