SFH-35-O

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-35-O is a low chromium alloy self-shielding hard bread welding wire, which can be used for general low wear welding or transition priming.
- It is especially suitable for regenerating workpieces worn by impact or shoveling, such as crawlers, guide wheels, sprockets, idlers, etc. in excavators or conveying roller axes in steel mills.

NOTE ON USAGE :

- If the workpiece is carbon steel, low alloy steel or cast iron, it should be preheated to 200 ˚C first.
- Stress relief annealing at 450 ˚C after welding can avoid cracks caused by excessive stress.

Typical Chemical Composition Of Weld Metal (wt%):

C	Mn	Si	Cr	Al
0.18	2.52	0.55	1.25	1.7

HARDNESS :

Layers	1st layer	2nd layer	3rd layer
Hardness (HRC)	23-29	27-32	31-36

Size And Recommended Current Range : DC(+)

Diameter (mm)	Voltage (V)
2.8	27-30
Current (A)	Stickout (mm)
250-400	50-70

SFH-41-O

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FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-41-O low chromium alloy steel self-shielding hard welding wire is especially suitable for metal-to-metal wear.
- Applicable occasions include hard surface or backing repair of crawler, guide wheel, dredger parts, gears and other workpieces.

NOTE ON USAGE :

- If the base metal is high carbon steel or alloy steel, please apply preheating and interlayer temperature of 150 ~ 250 ˚C.
- After welding, post-heat treatment at about 450 ˚C is applied to eliminate internal stress.

Typical Chemical Composition Of Weld Metal (wt%):

C	Mn	Si	Cr	Mo
0.25	2.50	0.35	1.10	0.40

HARDNESS :

Layers	1st layer	2nd layer	3rd layer
Hardness (HRC)	28-34	39-44	42-47

Size And Recommended Current Range : DC(+)

Diameter (mm)	Voltage (V)
2.8	27-30
Current (A)	Stickout (mm)
250-400	50-70