

FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SFH-56-O is a self-shielding hard bread welding wire with excellent wear resistance and general impact wear resistance.
- After welding, the appearance of the welding channel is smooth, and the number of welding and repairing layers should not exceed two layers. It is suitable for welding and repairing the hard surface of new products or recycled workpieces of carbon steel, low alloy steel and manganese steel, such as shaft sleeves, cement mixers, top edges of dredging knives or digging knives, bulldozer stacking shovels and many other workpieces.

NOTE ON USAGE :

- After welding, the molten gold cannot be machined and can only be ground with grinding wheels.
- During repair, if the workpiece is high carbon steel or alloy steel, and the surface curvature is too large, the thickness is too thick or the shape is too complex, the welded bead is easy to generate high internal stress to cause cracking after welding. Therefore, the preheating temperature and interlayer temperature should be controlled at 150 ~ 250 °C, and slow cooling treatment should be carried out after welding.
- When the weld height reaches more than 6mm (no more than two layers), stress relief at a temperature of 420 ~ 480 °C shall be applied after welding.

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr	Mo
0.48	1.25	0.68	6.23	0.85

HARDNESS :

Hardness (HRC) 2 nd layer	52-60
--------------------------------------	-------

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

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