

# SFH-61-O

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-61-O is a self-shielding hard bread welding wire. The dissolved gold is primary carbide and eutectic structure. It has high hardness and excellent wear resistance.
- It is suitable for welding and mending many workpieces such as coal pulverizer, cement mixer, dredger cutter, bulldozer shovel and so on.

### NOTE ON USAGE :

- The number of welding layers should not exceed two. If the workpiece is carbon steel, low alloy steel or cast iron, it should be preheated to 200 °C first.
- After welding, the molten gold cannot be machined and can only be ground with grinding wheels.

### Typical Chemical Composition Of Weld Metal (wt%) :

| C    | Mn   | Si   | Cr    |
|------|------|------|-------|
| 3.00 | 0.73 | 1.10 | 22.00 |

### HARDNESS :

| Layers         | 1 <sup>st</sup> layer | 2 <sup>nd</sup> layer |
|----------------|-----------------------|-----------------------|
| Hardness (HRC) | 54-57                 | 57-61                 |

### Size And Recommended Current Range : DC(+)

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

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## FCAW WELDING FOR HARD SURFACE WEAR RESISTANCE

### DESCRIPTION & APPLICATIONS :

- SFH-65-O is a self-shielding hard bread welding wire with high chromium carbide precipitation and high temperature alloy elements.
- Applicable occasions are hard surface repair with high wear and low impact, such as coal roller, ghost tooth, blast coal cover, grinder parts, etc.

### NOTE ON USAGE :

- After welding, the hardness of molten gold is extremely high, which cannot be machined only by grinding wheels.
- Do not do heat treatment for welded gold.

### Typical Chemical Composition Of Weld Metal (wt%) :

| C    | Mn   | Si   | Cr   |
|------|------|------|------|
| 4.86 | 0.40 | 0.50 | 17.5 |
| Mo   | W    | Nb   | V    |
| 4.90 | 1.20 | 5.23 | 0.80 |

### HARDNESS :

| Hardness (HRC)        | 常温硬度  | 高温硬度 600 °C |
|-----------------------|-------|-------------|
| 2 <sup>nd</sup> layer | 62-65 | 52-56       |

### Size And Recommended Current Range : DC(+)

| Diameter ( mm ) | Voltage (V)   |
|-----------------|---------------|
| 2.8             | 27-32         |
| Current (A)     | Stickout (mm) |
| 250-400         | 50-70         |