

SAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-45R is a titanium ore series electric welding rod, and the structure of the filler metal is fertilizer grain iron plus snow carbon iron.
- It is suitable for transmission gear, idler, pulley, crawler, gravel roller, mud shovel, mud bucket, chain, axle and other parts.

NOTE ON USAGE :

- Before welding, the welding rod should be dried at 120°C for 60 minutes, and a small amount should be taken out and put into heat preservation at 100 ~ 150°C when in use. In the drying cylinder, the maximum amount of weld carried out should be the same day.
- It is suggested to preheat the base metal above 150°C first.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.24	1.28	0.36	2.43

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 ° C under	410	42	56
pile up welding	380	39	52
900° C water quenching	470	47	63

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Current (Amp)	80-120	120-170	160-210