

SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-80R belongs to titanium ore series electric welding rod, which is self-hardening Matian loose iron structure.
- It has good arc restart during welding, and is suitable for pump barrel, cutter, pump barrel vane, earth stacker and other parts.

NOTE ON USAGE :

- Before welding, the weld should be dried at 120°C for 60 minutes. When in use, a small amount should be taken out and put into a drying cylinder with a heat preservation of 100 ~ 150°C. The maximum amount of weld carried out should be the same day.
- The base metal should be preheated above 150°C first.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
0.37	0.48	0.52	5.41

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition	Vicker's (HV)	Rockwell's (HRC)	Shores's (HS)
Layer temperature 150 ° C under	600	55	74
pile up welding	500	49	66
900° C water quenching	635	57	77

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