

SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

DESCRIPTION & APPLICATIONS :

- SH-80W is a low hydrogen electric welder with self-hardening Martian loose iron structure.
- It is most suitable for repairing and heap welding of mechanical parts with high wear resistance requirements, with excellent workability and welding slag peeling, and difficult machining.
- Applicable to pump drum, screw conveyor, sugarcane knife, sugarcane, earth stacker parts, etc.

NOTE ON USAGE :

- Before welding, the weld should be dried at 300 ~ 350°C for 30 ~ 60 minutes. When in use, a small amount should be taken out and put into a drying cylinder at 100 ~ 150°C. The maximum amount of weld carried out should be the same day.
- The base metal is preheated at a temperature above 200°C.
- Low hydrogen welding material is recommended for backing welding material.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr	Mo	W
0.67	1.18	1.26	7.10	1.42	2.30

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition		Vicker's (HV)		Rockwell's (HRC)		Shores's (HS)	
Layer temperature 150 °C under		680		59		80	
pile up welding		660		58		79	
High temperature hardness	Temperature(°C)	200	300	400	500	600	700
	Vicker's (HV)	530	490	440	430	210	100

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