SH-95HC

AWS –
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SMAW WELDING FOR HARD SURFACE WEAR RESISTANCE

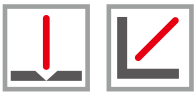
DESCRIPTION & APPLICATIONS :

- SH-95HC is a low-hydrogen electric welder, and the dissolved gold is a primary carbide and eutectic structure.
- The content of chromium carbide is high, and the hardness has little downward trend at high temperature, so it has good high temperature wear resistance and excellent corrosion resistance, and is suitable for stirring blades, cutters, sieves, 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 400°C.
- It is preferable that the number of welded layers should not exceed 2 or 3 layers.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Cr
5.13	3.00	0.20	26.5

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

Condition		Vicker's (HV)		Rockwell's (HRC)		Shores's (HS)	
Layer temprature 150 °C under		700		60		81	
pile up welding		680		59		80	
High temperature hardness	Temprarture(°C)	200	300	400	500	600	700
	Vicker's (HV)	610	440	400	310	210	95

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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Current (Amp)	90-140	140-180	190-220