

SHF 325

Submerged Arc Welding Flux - Hardfacing Applications

Standards

EN ISO 14174	SA CS 3
TS EN ISO 14174	SA CS 3

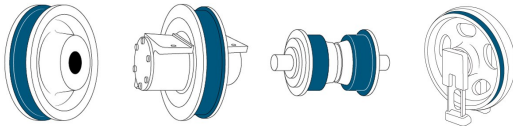
Properties and Applications

Alloyed and agglomerated flux, which is designed for submerged arc hardfacing of parts subjected to metal to metal friction wear, moderate impact and low stress mineral abrasion. Provides weld metal with 225-300 HB hardness, when used with SW 702 wire electrode. Possible to use in direct current. Hardness and transfer of alloying elements to the weld metal depends on welding parameters used. For instance, optimum welding parameters for 4.00 mm wire electrode are about 600 A, 32 V, 50 cm/min. welding speed. Gives very smooth and clean weld bead surfaces, slag removal is very easy and generally slag is self releasing.

Typical Applications: Suitable for hardfacing of machine gear parts, rails, supports rolls of caterpillars, pulleys, locomotive wheels, table and support rolls in iron and steel industry.



Typical Applications



Typical Chemical Values of Weld Metal

Welding Wire	Type of Analysis	C	Si	Mn	Cr	Mo
SW 702	Weld Deposit	0.15	0.60	1.50	1.00	0.25

Typical Mechanical Values of Weld Metal

Test Condition	Welding Wire	Hardness (HB)	Hardness (HRC)
As welded	SW 702	225-300	20 - 32

Application Information

Welding Positions



PA PB

Welding Parameters & Efficiency

Polarity:



Packaging Information

Product Code	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
408010AGM2	25 kg	25.60	1	25.60	Craft Bag

Storage & Re-Drying Information

Generally not required. If required, redry for 1 hour at 110°C. During transportation and storage, it should be ensured that the packaging is not damaged or torn. It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets. It has to be dried at 350°C for 2 hours.