

# Metal to metal abrasion resistant

## **GH450**

JIS Z 3251 DF2A-450B

### Product Features:

- Weld metal typical hardness approximately HRC44.
- Martensite structure self-hardening weld metal.
- Good resistance to moderate impact and abrasion conditions.

### Applications:

- Suitable for buildup, hardfacing and repair welding of metal to metal abrasion worn out machine parts on quarry machine, bulldozer chain gear, shovel bucket, caterpillar band, shovels teeth, and cutters, etc.

#### Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo
0.21	0.58	1	1.70	0.49

#### Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
44	37

#### Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/400	5.0/450	6.0/450
Flat position	100~140	140~190	180~230	240~300

### Note:

- 300~350°C x 1 hr baking prior to use.
- Keep short arc length while welding.
- Recommend to apply low hydrogen electrode on buffer layer for high hardenability base metal or multiple passes welding.

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