

Metal to metal abrasion resistant

GH450R

JIS Z 3251 DF2B-450R

Product Features:

- Weld metal typical hardness approximately HRC47.
- High welding performance, less spatter loss and good bead appearance.
- Martensite structure weld metal to get good abrasion resistance.

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
0.35	0.26	0.62	3.50	0.52

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
47	36.3

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/350/450	6.0/450
Flat position	70~100	100~140	140~190	180~230	240~300

Note:

- 100~120°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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