

Hardfacing SMAW - Metal to metal abrasion resistant

GH600

JIS Z 3251 DF3C-600B

Product Features:

- Martensite structure self-hardening weld metal.
- Weld metal typical hardness approximately HRC55.

Applications:

- Suitable for build up and repair welding of high wear resistance and none-post machining required worn out machine parts on quarry machine, shovels teeth, crusher, fork lift, dredge, stone agitator, pump blade, screw conveyer, etc.

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

C	Si	Mn	Cr	Mo
0.77	0.81	1.14	4.93	0.01

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
54	45

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.
- Surface dirt such as grease or rust on groove side or repair area to be completely removed before welding.

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