

HardFacing SMAW - Metal to metal abrasion resistant

GH600R

JIS Z 3251 DF2B-600R

Product Features:

- Titanium oxide type covered electrode, good for metal-to-metal abrasion resistance.
- High welding performance, less spatter loss and good bead appearance.
- Weld metal typical hardness approximately HRC55.
- Martensite structure weld metal to get good abrasion resistance.

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
0.34	0.34	0.62	3.88	0.74

Typical hardness of weld metal

As welded HRC	Tempering 600°C HRC
56	45

Size (mm) & recommended welding parameters (A)

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450	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.
- Surface dirt such as grease or rust on groove side or repair area to be completely removed before welding.

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