

Metal to sand abrasion resistant

GH900

JIS Z 3251 DF5A-700B

Product Features:

- Weld metal contains many different alloy elements to get high hardness carbide structure.
- High hardness over all weld metal surface, less impact toughness than GH900W; No post heat treatment required, good wear and crack resistance.

Applications:

- Suitable for repair welding of high speed steel tools and cutters.

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

C	Si	Mn	Ni	Cr	Mo	W
0.90	0.80	0.45	0.03	4.85	7.81	1.99

Typical hardness of weld metal

As welded HRC	layers
61	2

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/350	5.0/450	6.0/450
Flat position	90~140	140~190	180~230	240~300

Note:

- 300~350°C x 1 hr baking prior to use.
- Recommend preheat or post heat to reduce residual stress for welding high hardness and brittleness Martensite base metal.

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