

Hardfacing and Wear Resistant SAMW Electrodes

GH900W

Product Features:

- Weld metal contains many different alloy elements such as Cr, W, Mo to get high hardness carbide structure.
- High hardness, good wear and impact resistance.
- Martensite structure weld metal.

Applications:

- Suitable for hardfacing repair welding of alloy steels, press dies.
- Repair welding of tool steels.

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

C	Si	Mn	W	Cr	Mo
0.54	0.41	0.25	8.64	8.11	3.66

Typical hardness of weld metal

As welded HRC	layers
58	2

Size (mm) & recommended welding parameters (A)

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

Note:

- 200~250°C x 1 hr baking prior to use.
- Max. 2 layers.
- Min. preheat 250°C to reduce cooling rate for avoiding crack.

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