

Hardfacing SMAW (Severe Abrasion resistant)

GH900Mn

Product Features:

- Carbon and chromium as major elements.
- Weld metal contains many different alloy elements such as Nb, V, Mo, W to get high hardness carbide structure.
- Wear resistance at elevated high temperature $\leq 816^{\circ}\text{C}$.
- Good corrosion and oxidation resistance at elevated high temperature.

Applications:

- Suitable for hardfacing repair welding of blast spray nozzle and agitator blade.

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

C	Si	Mn	Cr	Mo	Nb	W	V
5.66	1.36	1.42	23.2	5.4	5.4	1.7	1.1

Typical hardness of weld metal

As welded HRC	layers
63	2

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/400	5.0/450	6.0/400
Flat position	80~120	140~170	180~230	230~280

Note:

- 200~250°C x 1 hr baking prior to use.
- Max. 2 layers.
- Typical stress crack occurred to prevent peeling damage between base and weld metal.