

Severe Abrasion resistant

GH950Nb

Product Features:

- Carbide precipitation type covered electrode, C, Cr, Nb as major elements.
- Wear resistance at elevated high temperature $\leq 650^{\circ}\text{C}$.
- Good for repair welding of workpiece subjected to low stress and severe wear condition.

Applications:

- Suitable for repair welding of wear resistant plates, coal crusher wheel, slag crusher axle tube and breaker, etc.

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

C	Si	Mn	Cr	Nb
6.30	1.03	0.81	25.4	5.7

Typical hardness of weld metal

As welded HRC	layers
64	2

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/350/400	5.0/450
Flat position	100~150	150~200	180~240

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.