

# Hardfacing & Wear Resistant SMAW Electrode

## GH950

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### Product Features:

- High chromium carbide precipitation type covered electrode.
- High hardness and good wear resistance.
- Wear resistance at elevated high temperature  $\leq 500^{\circ}\text{C}$ .

### Applications:

- Suitable for repair welding of heavy metal-to-sand worn out machine parts.

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

C	Si	Mn	Cr
4.66	0.93	0.99	33.6

Typical hardness of weld metal

As welded HRC	layers
62	2

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/400	4.8/400	5.0/400
Flat position	100~150	150~200	170~230	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.

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