

Severe Abrasion resistant

GHCW

Product Features:

- High Tungsten carbide precipitation type covered electrode.
- High weld metal hardness to get very good wear resistance.
- High welding performance, less spatter loss and low dilution ratio.

Applications:

- Suitable for repair welding of heavy worn out machine parts such as shovel teeth, drill bit, scraper cutter and agitator screw blades, etc.

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

| C | Si | Mn | W |
|------|------|-----|------|
| 4.10 | 1.85 | 0.6 | 42.0 |

Typical hardness of weld metal

| As welded HRC | layers |
|---------------|--------|
| 65 | 2 |

Size (mm) & recommended welding parameters (A)

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

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.
- Min.150°C preheat on base metal before welding.

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