HYUNDAI WELDING

Rev. 03

Supershield CrCH

CHROMIUM CARBIDE TYPE OPEN ARC WIRE

HYUNDAI WELDING CO., LTD.

Supershield CrCH

❖ Specification

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❖ Description & Applications

Supershield CrCH is an open arc wire used for hardfacing components subject to extreme abrasion/erosion and moderate/heavy impact. Especially, single layer deposit make sure of high hardness. (Crush rolls, Wear plate, Earth engaging tools etc.)

❖ Welding Process

Open Arc Type

❖ Current Type

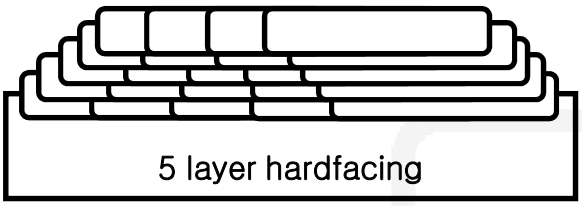
DC+

❖ Packing

Supershield CrCH	**Dia.**	2.8mm(7/64in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	:	2.8mm(7/64in)
Welding Type	:	Open Arc
Amp./ Volt.	:	380/30
Stick-Out	:	25~30mm(0.98~1.18in)
Pre-Heat	:	150~250℃(302~482°F)
Interpass Temp.	:	200~300℃(392~572°F)
Total layers	:	≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr
Supershield CrCH	5.0	0.8	0.2	28.0

❖ Hardness test of All weld metal(HRc)

Consumable		Hardness(HRc)					Avg.
Supershield CrCH	**1 layer**	58	58	59	61	61	59.5
	2 layer	61	61	62	62	63	62
	Multi layer	64	65	65	66	67	65

Test Results

❖ BEAD APPEARANCE

Consumable	Supershield CrCH
Amp.(A)	380~400
Volt.(V)	28~30
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)