

Supershield CrCH

CHROMIUM CARBIDE TYPE OPEN ARC WIRE

HYUNDAI WELDING CO., LTD.



Supershield CrCH

❖ Specification

-

❖ 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+

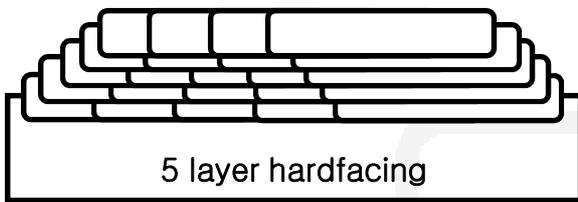
❖ Packing

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



5 layer hardfacing

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

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



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)



This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.