

Supershield CrCMo

CHROMIUM CARBIDE + Mo TYPE OPEN ARC WIRE



Supershield CrCMo

❖ Specification

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❖ Description & Applications

Supershield CrCMo is an open arc wire used for hardfacing components subject to extreme abrasion/erosion and moderate/heavy impact.

(Gyratory Crusher, Crusher & Coke Hammers Chemical Pipe etc.)

❖ Welding Process

Open Arc Type

❖ Current Type

DC+



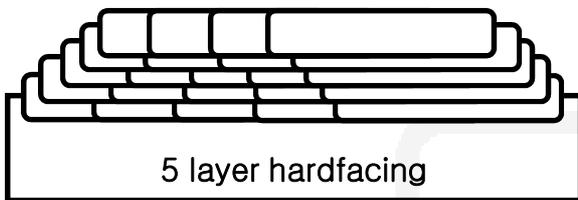
❖ Packing

Supershield CrCMo	Dia.	2.4mm(3/32in) 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	: 2.4mm(3/32in)
Welding Type	: Open Arc
Amp./ Volt.	: 360 / 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	Mo
Supershield CrCMo	5.0	1.2	0.4	27.0	1.2

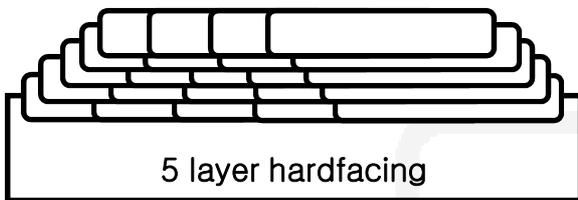
❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield CrCMo	58	59	62	63	63	61.0



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	Mo
Supershield CrCMo	5.0	1.1	0.4	26.5	1.1

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield CrCMo	59	60	61	63	64	61.4



Test Results

❖ BEAD APPEARANCE

Consumable	Supershield CrCMo (2.4mm, 3/32in)
Amp.(A)	330~350
Volt.(V)	29~30
Carrige Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



Consumable	Supershield CrCMo (2.8mm, 7/64in)
Amp.(A)	360~380
Volt.(V)	29~30
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.