

## SAS 550-VW

**CATEGORY** ESW Electroslag

**TYPE** Sintered hardfacing strip for rebuilding and overlay applications.

**APPLICATIONS** Rebuilding wornout parts such as screws, chruser hammers, drive tumblers, chruser rolls, dredging parts etc...

**PROPERTIES** The weld deposit offers excellent wear resistance against shocks and abrasion as well. Already the first layer gives excellent results even on mild steel due to the low dilution of the electro slag process. Due to the low dilution with the base metal a hardness exceeding 50 HRc can be achieved already in the first layer. Multiple layers can be applied to obtain full hardness at the final layer.

**SUITABLE FOR** 52-58 HRc electro slag and / or submerged arc strip for hardfacing against schock and wear, Rebuilding wornout parts such as screws, chruser hammers, drive tumblers, chruser rolls, dredging parts etc.. For ESW welding **FL 830 ESHC** should be used as welding flux to obtain the results mentioned in this datasheet.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	W	Cr	Ni	Mo	V
0.33	2.8	1.8	7.0	0.25	1.7	0.25

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							52-58

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			
(mm)	Voltage (V)	Current (A)	Flux height
0,5 x 30	22-24	500-625	17-22 mm
0,5 x 60	22-24	1050-1350	22-27 mm

**REDRYING TEMPERATURE** 150` C / 24hr (normaly not needed)