

# Supershield AP-0

High Mn/Cr Type

## Conformances

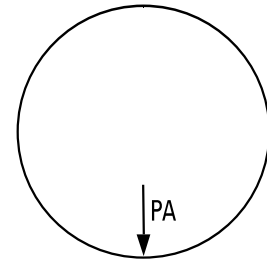
## Applications

- Crusher rolls and hammers, cone mills

## Features

- Open arc type hardfacing wire(buffer layer)
- High-Mn/Cr type

## Welding Position



## Current

DC +

## Welding Process

Open Arc

## Diameter / Packaging

Diameter	Spool		Coil	Pac		
	12.5kg (27.6lbs)	15kg (33lbs)	25kg (55lbs)	150kg (330lbs)	250kg (551lbs)	350kg (771lbs)
1.2 (0.045)						
1.6 (1/16)			√			
2.4 (3/32)			√	√	√	
2.8 (7/64)			√	√	√	
3.2 (1/8)						

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	Cr
As welded with 1.6/2.4/2.8mm wire	0.4	0.4	16.0	13.0

## Typical Mechanical Properties of All-Weld Metal

	Rockwell Hardness(HRc) ( $\geq 3$ layers)	
	As welded	Work hardened
On Mild Steel (1.6/2.4/2.8mm)	15~20	40~50

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
<b>1.6mm (1/16 in) DC+</b>					
Open Arc	25 (1)	4.9 (192)	240	26	3.4 (7.5)
		7.3 (287)	280	29	4.5 (9.9)
		11.2 (440)	330	30	5.4 (11.9)
<b>2.8mm (7/64in), DC+</b>					
Open Arc	25 (1)	2.9 (114)	330	27	5.0 (11.0)
		3.3 (130)	360	29	5.7 (12.5)
		3.8 (149)	400	30	6.5 (14.3)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX