

WELDING RECOMMENDATION SHARQPLATE

Areas of use

SharqPlate is recommended for applications where equipment needs to be protected from abrasive wear.

Material properties

SharqPlate is a hardened boron steel according to EN 10083-3. The material properties, the hole pattern and the hardening process ensures good wear resistance.

Shaping & preparations

SharqPlate can be cut using an angle grinder or torch.

SharqPlate is not suitable for bending.

Ensure that the SharqPlate is fitted flat against the surface, avoid gaps.

Ensure that the bottom surface is free from paint, rust & moisture.

Pre-heating

To avoid cracking, the SharqPlate & bottom surface should be pre-heated to 50-75 degrees C / 120-170 degrees F before welding.

Welding

Olofsfors recommends electric welding (MMA) or MAG welding.

MMA: recommended welding rod ESAB OK 48.00, or rods equivalent to SFA/AWS A5.1 : E7018.

MAG solid wire: recommended welding wire ESAB OK AristoRod 12.50 / 12.51 or wire equivalent to SFA/AWS A5.18 : ER70S-6.

MAG metal core wire: recommended welding wire ESAB OK Tubrod 14.11 / 14.13 or wire equivalent to SFA/AWS A5.18 : E70C-6M.

Argon gas with 16% to 23% CO₂ is recommended as shielding gas (M21).

Welding pattern & size

Please see illustrations, next page, for the recommended welding pattern and welding size.

RECOMMENDATION ON WELDING PATTERNS

