

ELECTRODE FOR SURFACING CARBON AND MANGANESE STEEL WITH HIGH DEPOSITION RATES

Alloy Basis

Cr, Ni, Mn

Characteristics :

SME A08HC electrode produces weld deposits that can withstand high impact and are highly resistant to cracking. This exceptional combination of properties provides versatility allowing them to function as both a joining electrode and as an electrode for wear protection or cushion layer applications. The deposits work-harden during service delivering excellent results on carbon steels manganese steels or dissimilar combinations of these materials.



Typical Applications

Typical applications include Manganese Filler bars, Conveyor Buckets, Ripper Shanks, Dozer Cutting Edges, Screw Conveyor Flights, Loader Scoops, Wheel Flanges Augers, Impactors, Pump Casings, Scraper Blades, Crusher Rollers & Jaws, Sprockets, Gear Teeth, Trencher Teeth, Hammers, Undercarriage Components etc.

Mechanical Properties

Tensile Strength: 65 KG / mm²

Hardness: As deposited : 85 - 95 HRB

Work hardened: 25 - 35 HRC

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	60 - 90	90 - 130	120 - 160	170 - 210

Availability:

Standard Size: 5.0, 4.0, 3.15, 2.5 in 350 mm length

Packing: 2 kg.

Procedure

Clean the weld area and remove all damaged or fatigued material. When joining heavy sections, bevel and preheat according to the carbon content and hardenability. After welding, slow cool the material using insulating materials such as vermiculite or heat-retardant blankets.