

ELECTRODE FOR TOUGH AND WEAR-RESISTANT AGAINST FRICTION

Alloy Basis

Cr, Mn

Characteristics :

The deposit is particularly resistant to mild impact and friction. Thick surfacing without intermediate layers possible. Basic coated, all position electrode



Typical Application

Surfacing of parts subject to wear by friction and mild impact. Rims, carbon-alloyed rails, dies, striking tools, rolling surfaces, sliding surfaces subject to heavy wear, stampers, etc. also ideally suited for construction & mining machinery parts like drive sprockets, rollers, concrete mixer blades, pumps, conveyor, screws, pinions and girth gear. The right choice for providing buffer layers where friction, mild impact and abrasion occur together.

Mechanical Properties

Hardness : 25 – 35 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 160	160 - 200

Availability:

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

Packing: 2 kg.

Procedure

Clean the weld metal surface, Use a short arc holding electrodes at an angle of 60 degree to the horizontal and lay stringer beads. Weld 2-3 layers. Finish weld metal by machining to the required size. do not allow excessive heat build up.