

## ELECTRODE FOR APPLICATIONS SUBJECTED TO SEVERE ABRASIVE WEAR

### Alloy Basis

C, Cr, Ni, Mo

### Characteristics :

This electrode is specially designed to achieve a spatter-free, dense weld deposition that resists high abrasion, provides rapid deposition, and can be used in all welding positions.



### Typical Application

Used for surfacing applications on buckets, shovels, drills, scrapers, pulverizers, and cultivators. This electrode provides high wear resistance against abrasion and moderate impact.

### Technical Data:

Hardness: 58 – 63 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 & 450 mm length

Packing : 2 & 5 Kgs

### Procedure

Clean the weld metal surface, preheat heavy sections to about 200 to 250 °C. Use stringer or weaving technique holding a short to medium arc. Finish weld metal by grinding to the required size. Do not allow excessive heat buildup. Chip the slag between the passes and allow the deposit to cool.