

ELECTRODES WITH HIGH ABRASION RESISTANCE AND EXTRA HIGH DEPOSITION RATES

Alloy Basis

Cr, Mn, C

Characteristics :

The electrodes produce a hard, wear-resistant Chromium carbides weld deposit. A maximum of two layers should be deposited. The second layer may exhibit fine 'relief cracks,' which are not detrimental to the integrity of the weld deposit or the job.



Typical Applications

Electrodes are used for hardfacing applications such as cement die rings, muller tyres, plough shears, crusher hammers in cement plants, agitator blades, scraper blades, conveyor screws, clay extruder screws, and coal crusher rolls in thermal power plants.

Mechanical Properties

Hardness :

As welded : 60 – 68 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	100 - 120	130 - 170	180 - 200

Availability:

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

Packing: 2 kg.

Procedure

Clean the weld metal surface by Grinding, Deposit holding short arc. Minimum two layers to be deposited holding the electrode at 90 Degree to the weld surface. single pass overlay is normally recommended .