

A UNIQUE ELECTRODE WITH HIGH CHROMIUM CARBIDE DEPOSITS FOR ABRASION, EROSION AND CORROSION

Alloy Basis

C, Cr, Nb

Characteristics :

Electrodes has smooth and forceful arc with good weld ability. Easy Slag detachability. giving uniform, shining and porosity free glossy weld beads. chromium carbides are evenly distributed in the weld metal. Useful for applications where a combination of toughness, heat and hardness is desired.



Typical Applications

Electrodes Used for Conveyor screw flights, mixer blades, auger screws, dredging cutter, runner bottom edge, pug mill, blast furnace bells & hoppers. Hard surfacing of parts which are subject to severe abrasive wear and moderate shocks.

Mechanical Properties

Hardness : 55 - 62 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	80 - 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 by wire brush, Hold electrode at approximately 90 degree to the surface and deposit the weld beads. Chip the slag between passes. Maximum two to three layers can be deposited