

DESCRIPTION

Hard surfacing electrode with excellent abrasion resistance at high temperatures and exceptional Metal recovery (240 %).

ALLOY BASIS

Fe, Cr, Cb, V, Mo, W, C

APPLICATIONS

For surfacing of hopper and protection plates in quarries, ore crushing rolls, gyratory crushers, ore breaker teeth, scraping beaks, sinter plant disintegrators, blast furnace bells and hoppers.

PROCEDURE

Use a medium/long arc. To prevent excessive dilution with parent metal use low amperage. The recommended hardness is obtained only in the second or third layers.

TECHNICAL DATA

Hardness at room temperature : 57 - 63 HRC
Hardness at 600°C : 40 - 43 HRC

WELDING PARAMETERS

Size (diameter)/length (mm) :	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps) :	70 - 90	100 - 120	120 - 140	140 - 160
Current :	AC/DC (+)			