

Properties

Thick basic coated electrode for depositing tough and wear resistant overlays on components subject to severe wear. The weld metal is crack-free and without porosity and resistant to impact and shock. It can be machined only by grinding. It is possible to deposit a large number of layers without the need of buffer layers.

Application

Excavator parts, bucket edges, coal planes, conveyor screws etc.

Weld Metal Analysis Typical values

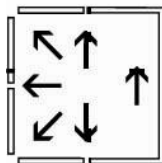
Carbon: 1.30
Chromium: 20.0
Manganese: 1.40

Typical Mechanical properties

Hardness (As Welded)

53-58 HRC

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	300	60-80
3.2	350	100-140
4.0	350	140-190
5.0	350	190-250