

FINE HARDEX – I

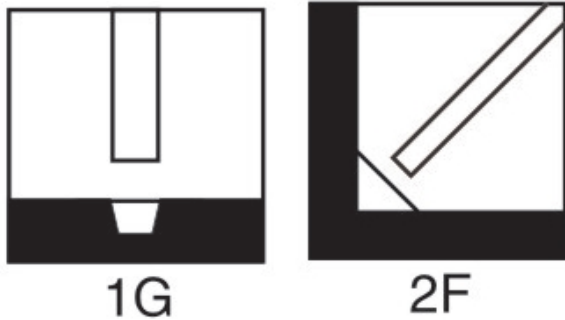
CHARACTERISTICS :-

A medium-heavy-coated, Rutile type electrodes, deposits air hardening type weld metal of approximately 250 brinell hardness. The weld metal is machinable. A buffer layer of FINE LH 16 is recommended on hard - base materials. Welds normally machinable.

TYPICAL APPLICATIONS :-

Gears , Shaft , Pinion teeth , Hammers, Gear wheels, subject to friction and abrasion.

WELDING POSITION :-



CHEMICAL COMPOSITION :-

	Min	Max
C	-	0.16
Cr	0.40	0.75
Mn	1.00	1.50
Mn	0.15	0.40
Si	-	0.25
S		0.03
P		0.03
Fe		Bal

ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 25 HRC

WELDING CURRENTS (AMPS) AC/ DC (+)

	Min	Max
3.15 X 350 MM.	100	140
4.00 X 350 MM.	140	180
5.00 X 350 MM.	170	230

NECESSARY CARE :-

Redry Electrode 100°C 2 hours before use.

Clean weld area free of rust, oil, grease, paint or any other surface contamination.