

FINE HARDEX – II

CHARACTERISTICS :-

A medium-heavy-coated, Rutile type electrodes, deposits air hardening type weld metal of approximately 350brinell harness. The weld-metal is machinable with carbide tools A buffer layer of FINE LH 16 is recommended on carbon steels and low alloys steels. Welds machinable with good cutting tools.

TYPICAL APPLICATIONS :-

Gears shaft , Pulleys , shear blades , sprockets, cold punching dies subject to friction & abrasion.

WELDING POSITION :-



CHEMICAL COMPOSITION :-

	Min	Max
C	-	0.30
Cr	2.50	3.50
Mn	0.40	0.70
Cr	2.50	3.50
Si	0.20	0.40
S		0.03
P		0.03
Fe		Bal

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ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 35 - 40 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.