

FINE HARDEX – III

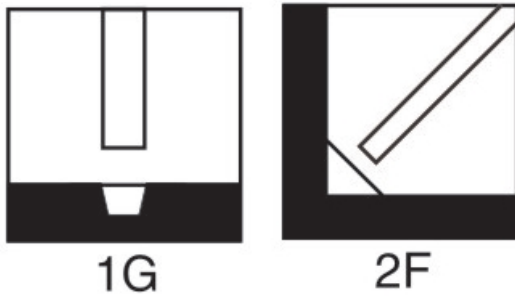
CHARACTERISTICS :-

A medium-heavy-coated, Rutile type electrodes, deposits air hardening type weld metal of approximately 550brinell harness which is non-machinable possible. The weld deposit has excellent resistant to abrasion and moderate resistance to impact. For high impact equipment buffer layer is recommended. Smooth arc least spatter, slag easily detachable, Use short are and Stringer bead technique.

TYPICAL APPLICATIONS :-

Metal cutting & forming tools, Crusher hammer, cane cutting knives, dipper teeth, shear blades and such other part subject to friction and abrasion.

WELDING POSITION :-



CHEMICAL COMPOSITION :-

	Min	Max
C	0.40	0.70
Cr	7.00	8.00
Molly	0.50	0.70
V	0.40	0.60
Si	0.20	0.40
Mn	0.40	0.60
Fe		Bal

ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 55 - 57 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.