

FINE HF-60C

CHARACTERISTICS :-

Rutile based heavy coated high chromium Carbide Electrodes has excellent abrasion resistance with mild impact. Specialty of electrodes is smooth running. Few crack possible on surface layer welding. The weld deposit is finish by grinding only. Use short arc and stringer bead technique for better hardness.

TYPICAL APPLICATIONS :-

Grinding Rollers, Crusher hammer, mixer blades, Expeller worm, Bucket teeth, steel pant pinch roller and such other part subject to friction and abrasion.

WELDING POSITION :-



CHEMICAL COMPOSITION :-

	Min	Max
C	3.50	4.50
Cr	28.00	30.00
Molly	0.50	0.80
Mn	0.50	0.70
Si	0.80	1.40
fe	-	Bal

ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 57-60 HRC

WELDING CURRENTS (AMPS) AC/ DC (+)

	Min	Max
3.15 X 350 MM.	100	160
4.00 X 350 MM.	150	200
5.00 X 350 MM.	210	270

NECESSARY CARE :-

Redry Electrode 200°C 2 hours before use.
Clean weld area free of rust, oil, grease, paint or any other surface contamination.
For better deposition rate use exact welding parameters while welding.