

FINE MH HARDEX III - 550

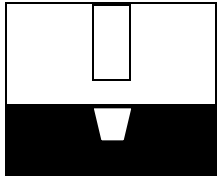
CHARACTERISTICS :-

MH HARDEX III – 550 basic hard facing wire giving air hardening weld metal approx. 550 Brinell hardness which is non-machinable only grinding possible. The Weld deposit has excellent resistant to abrasion and moderate resistance to impact. For high impact equipment buffer layer is recommended. (FINE LH 16 ELECTRODES). Smooth are least spatter, Slag easily detachable, Use short arc and stringer bead technique.

TYPICAL APPLICATIONS :-

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

WELDING POSITION :-



Wire Ø1.6 M.M.

Common Package 15 Kgs Spool



CHEMICAL COMPOSITION :-

	Min	Max
C	0.40	0.70
Cr	5.00	7.00
Molly	0.50	0.70
V	0.40	0.60
Si	0.50	0.80
Mn	0.70	0.90
Fe	-	Bal

ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 56 to 58 HRC

WELDING PARAMETERS (AMPS) AC/ DC (+)

DIAMETER IN MM	CURRENT (A)	VOLTAGE
1.2 MM	180 – 230	24 – 29
1.6 MM	200 – 250	26 – 30

NECESSARY CARE :-

Redry wire spool 50° C 2 hours before use.

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

SHIELDING GAS :-

100 % CO₂