

MH-520CF-O

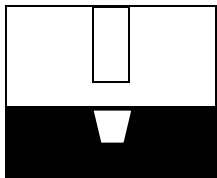
CHARACTERISTICS :-

MH - 520CF Chromium hardfacing flux cored wire has good abrasion resistance with medium impact the wear resistance overlaying on carbon steel, Low alloy steel, manganese steel and suitable for the middle low stress abrasive wear conditions.

TYPICAL APPLICATIONS :-

Grinding rollers, Crushing Hammers, Expeller worms, Bucket Teeth, Catter pillar Treads Mixer Blades, Cane cutting knives, Lining Bars, steel plant pinch rollers Etc.

WELDING POSITION :-



Wire Ø1.6 M.M.
Common Package 15 Kgs Spool
Special Packing as per order

CHEMICAL COMPOSITION :-

ELEMENT
Ca
Mn
Si
Cr
Fe

ALLOY HARDNESS :-

Rockwell Hardness HRC Three layer hard facing 53 to 55

HARDFACING PARAMETER (STRAIGHT FLOW REVERSE JOIN)

WIRES DIAMETER MM	WELDING CURRENT	VOLTAGE	WELDING SPEED MM MIN
1.6 MM	200 – 250	26 – 28	300 – 400

Noted :-

Few & hair line crack possible to visible on surface layer welding if layer is more than 1 Please used the welding speed & narrow welding width in order to improve the weld layer cracking morphology.

Please remove rust, oil and dust is to be welded before hardfacing.

The properties of surfacing alloy layer is related to the dilution rate of surfacing. General clear to used above three layers.

STATEMENT : THESE PAGE THE CONTENT AND DATA ONLY TYPICAL APPLICATION AS DESCRIBED AND CANNOT BE INTERPRETED AS FINEWELD ELECTRODES COMPANY OF PRODUCTS MADE BY THE GUARANTEE AND COMMITMENT PLEASE UNDERSTAND THE PRODUCTS.