

XHD 646

Manual Metal Arc Electrode For Intermediate Layers And Rebuilding

DESCRIPTION

High efficiency, austenitic manual electrode for intermediate layers and rebuilding 13 % manganese steel, alloyed steels and hardenable steels.

Product Details

- Very high resistance to impact
- Easy slag removal
- High work-hardening rate
- Machinable with tungsten carbide tip tool
- Corrosion resistance
- Smooth even appearance
- High metal recovery 150%

APPLICATIONS

Electrode for E+C TeroCote anti -wear protective coating of drive gears, lower guides and rollers of caterpillar tractors, conveyor rollers, rails and rail points, bearing plates, grading screens, gyratory crusher cones, drills, cylinder crushers, etc.

PROCEDURE FOR USE

Preparation

Remove all damaged and fatigued metal from areas to be overlaid and remove sharp edges. For large areas and where parts are subjected to high impact, prepare grooves 3 mm to 5 mm wide, approx. 6 mm depth, using ExoTrode

Preheating: Depends on the steel's Carbon Equivalent and the workpiece size, thickness and the geometry. Castolin Eutectic recommends:

CE < 0.2 : preheating not essential.

CE 0.2- 0.4: preheating 100-200°C

CE 0.4- 0.8: preheating 200-350°C.

Note that 12-14% Mn steels should never be preheated and that the workpiece temperature during welding should be kept below 250°C.

TECHNICAL DATA

Tensile strength: Min 550 N/mm² (80,000 psi)

Typical Hardness

As deposited: 90-100 HRB

Work hardened: 37-42 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	90-170
4.0mm	120-240
5.0mm	180-240

Note: For optimum result use the lowest amperage practical