

XHD AbraTec N^{*}6777

Special Electrode For Severe Abrasive Wear At Elevated Temperature

DESCRIPTION

An advanced electrode for overlaying of carbon steels & low alloy steels for applications involving abrasion and erosion at elevated temperatures. The weld deposit contains high percentage of refractory carbides, enabling abrasion at elevated temperature..

Product Details

- Carbides of Cr, Mo, Nb, W, V, Fe-Cr-C in eutectic matrix.
- Excellent resistance to wear upto 650 C.
- Easy handling with rapid deposition rate.
- Very high metal recovery.

APPLICATIONS:

Sinter star breakers, tip casting, coke pusher shoes, billet conveyer guide, hot slag conveyers, augers and clinker grinders.

Sinter cast rollers and table buttoning.

PROCEDURE TO USE:

Remove all damaged and fatigued weld metal and clean weld area. Maintaining short to medium arc length, deposit stringer and weaved beads. For medium carbon steels, preheat upto 250°C. Use EutecTrode 2B as cushion alloy if more build-up is required.

TECHNICAL DATA

Typical Hardness 65-68 HRC

Current polarity: AC/DC (-)

DIAMETER	AMPERAGE
3.2mm	100-140
4.0mm	140-160
5.0mm	150-180

Note: For optimum result use the lowest amperage practical