



Iron ore Crusher Roter

## High Hardness Tubular Electrode for Severe Abrasion Resistance

### Typical Applications:

ID fans, Crusher housing, Scrapper blades, Bucket teeth and Lips, Tooth points, Excavator parts, Conveyor chains, Mixer blades, Sludge pumps.

### Outstanding Features:

- High Single layer hardness (60HRC).
- High Wear factor > 50 (ASTM G65, Type A).
- Surfacing on inclined position with skilled operator.
- Surfacing with minimum heat input & low dilution.
- High deposition rate & metal recovery.

### Recommendation:

Innovative alloy containing innovatively strengthened austenite-eutectic matrix with excellent wetting of densely distributed fine boride and carbide phases. This high hardness alloy in tubular form enhances service life of components subjected to high abrasive wear conditions up to 300 °C.

### Procedure:

Clean weld area by removing fatigued & worn out surface. Use minimum amperage while surfacing to minimize heat input and base metal dilution and warpage on thin sections. Weld with short arc to deposit stringer beads. Back whip craters. For high carbon steels pre-heat upto 250°C and maintain inter-pass temperature. Use minimum 30% overlap between adjacent passes. Recommended upto 2 layers. Presence of fine stress relieving cracks may appear for this type of alloy system. Use low diameter tubular electrode for inclined positions. Smooth surface finish can be achieved by grinding.

### Recommended Amperages:

Size(mm)	Amperage
6.30	80-120
8.00	150-180

**Hardness:** 60 - 65 HRC (2 layer)