



Crowbar Hardfacing

Special electrode for severe abrasive wear at elevated temperature

Typical Applications:

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

Outstanding Features:

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

Recommendation:

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.

Procedure:

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.

Recommended Amperages:

Size(mm)	I-Range	II-Range
3.15	150-170	100-140
4.00	190-250	140-160

Hardness: 60 - 68 HRc (2 layer)