



Breaker Plate Hardfacing

An advanced wear facing electrode designed for severe abrasion applications under pressure and moderate impact

Typical Applications:

Table liners, roller liners, excavator buckets, dragger & shovel buckets. components subjected to severe grinding abrasion.

Outstanding Features:

- Unique product with vanadium carbide as the primary hard phase.
- Designed for 1-2 layer top coat over standard hardfacing to enhance service life.
- Easy handling, rapid deposition with little slag.
- Excellent resistance to severe abrasion upto 250° C.

Recommendation:

An advanced wear-facing electrode designed for severe abrasion applications on carbon steels, austenitic manganese steels etc. The weld deposit has very high content of

Super hard constituents, making it extremely resistant to intense abrasion under pressure and moderate impact.

Procedure:

Remove all damaged or fatigued weld metal and clean weld area. Maintaining medium arc length and electrode vertical, deposit stringer or weaved beads. Back-fill craters. Recommended for 1-2 layer max. For higher built-ups, use suitable base layer. (Example: XHD 646)

Recommended Amperages:

Size(mm)	I-Range	II-Range
3.15	100-140	100-120
4.00	130-170	130-150

Hardness: 60 - 65 HRc (2 layer)