XHD 646 ac / dc+



Crane Wheel Welding

A high alloy electrode for wear protective coating & high strength joining

Typical Applications:

For joining: Under carriage parts, sprockets, ripper shanks.

For Build-up: Gear teeth, impactors, sprockets, trencher teeth, bucket teeth, hammers, augers, under carriage components, scrapper blades, crusher jaws.

Outstanding Features:

- Excellent resistance to impact and scoring.
- Rapid hardening property.
- Excellent operating characteristics with fast deposition rate.
- Excellent crack resistance.

Recommendation:

A high alloyed electrode for similar & dis-similar joining, cladding applications subjected to compressive service. Outstanding weldability with extra high deposition rate. Weld metal is completely machinable with tungsten carbide tools.

Procedure:

Clean weld area. Deposit stringer beads or use 2X weave pattern. Back whip to fill up craters and remove slag between passes. Peen deposits where maximum crack resistivity is required. Cool naturally. On 14% Mn steel, use skip welding or back step technique to prevent heating above 150°C.

Recommended Amperages:

Size (mm)	l - Range	ll - Range
2.50	100 - 140	75 - 100
3.15	140 - 170	90 - 130
4.00	180 - 250	120 - 160
5.00	210 - 260	160 - 190

Hardness:

As deposited 80-90 HRb Work hardened 28-32 HRc Tensile Strength: 62 Kg/mm² (88,000 psi)

