



Hardfacing Electrode for Moderate
Abrasion – Extra Hardness Application
Medium Carbon Medium Chromium

Mechanical Properties:

Condition	Hardness, 3 layer
As welded	(500-600) HV

Salient Features

- Rutile electrodes and high metal recovery in hardfacing.
- Extremely hard weld deposit.
- Air-hardenable deposit.
- Good combination of abrasion and impact properties.

Applications

- Excavators, conveyor parts.
- Ploughshares.
- Girth gears in cement and power plants.
- Gear shafts.
- Shear blades.

Type of Current: AC /DC (Minimum 50 Volts)

Operating & Packing Information:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
3.20	450	3	100-140
4.0	450	3	140-180
5.0	450	3	180-220

Storage Instructions

Keep the electrodes in a dry place. Preheat at 110°C for 40-60 minutes before use.



Bulldozer Bucket Rebuilding



Ploughshare Rebuilding



Excavator Bucket Rebuilding



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Hardfacing Electrode for Moderate Abrasion – High Impact Application
Low Carbon Medium Chromium

Mechanical Properties:

Condition	Hardness, 3 layer
As welded	(350-450) HV

Salient Features

- Rutile electrodes and high metal recovery in hardfacing.
- Machinable with carbide tools.
- Air-hardenable deposit.
- Good combination of abrasion and impact properties.

Applications

- Excavators, conveyor parts.
- Ploughshares.
- Supporting rollers of kiln tyres.
- Girth gears in cement and power plants.
- Gear shafts.
- Shear blades.

Type of Current: AC/DC (Minimum 50 Volts)

Operating & Packing Information:

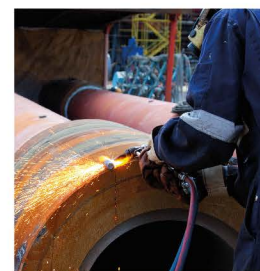
Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
3.20	450	3	100-140
4.0	450	3	140-180
5.0	450	3	180-220

Storage Instructions

Keep the electrodes in a dry place. Preheat at 110°C for 40-60 minutes before use.



Roller Rebuilding



Gear Rebuilding



Pump Shaft Rebuilding



Basic Type Hardfacing Electrode for High Abrasion, Moderate Impact Application
Medium Carbon High Chromium

Mechanical Properties:

Condition	Hardness, 3 layer
As welded	(600-700) HV

Salient Features

- Basic coated electrode resistance against high-stress abrasion and friction.
- Non-Machinable and air-hardenable weld deposit.
- Resistant to spalling and cracking.
- Can withstand moderate impacts.

Applications

- Excavator Teeth, Shear Blades.
- Crushers and Hammers.
- Crane Wheels, Bulldozer Blades and Bucket Tips.
- Disintegrating Hammers.
- Bamboo Cutting Knives.
- Metal to Mineral Wear Application.

Type of Current: AC/DC (OCV-70 V Minimum)

Operating & Packing Information:

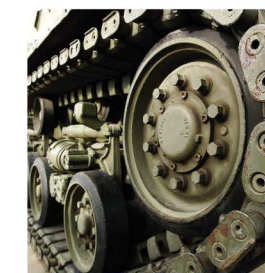
Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
3.20	350	3	100-130
4.0	350	3	140-180

Storage Instructions

Keep the electrodes in a dry place. Preheat at (250-300)°C for 60 minutes before use.



Forging Hammer Rebuilding



Forging Hammer Rebuilding



Crushers Rebuilding