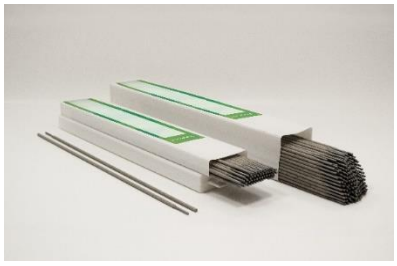
Spartex

TECHNICAL DATASHEET

Update: 18/11/2021

HARD FACING ELECTRODE HARD FACING

#item	EAN	Dimensions
853736	3660338097577	2.5 x 350 / ETUI 32 EE
853737	3660338097584	3.2 x 350 / ETUI 19 EE
853734	3660338097553	3.2 x 350 / ETUI 59 EE
853735	3660338097560	4.0 x 450 / ETUI 33 EE



Description

Synthetic rutile coated hardfacing electrode with high recovery (160%). For applications subject to abrasive wear by minerals, combined with medium impact and compression. Austenitic matrix containing Cr carbides. The deposit resists to corrosion due to the high chromium content as well as heat up to 200°C. Easy flow, smoth bead surface, self releasin g slag. Surfacing in 1 - 2 or eventual 3 layers for all pieces subject to high abrasion combined with a good resistance to shocks. Only machinable by grinding.

General applications

For excavating and crashing equipment, surfacing of endless screws, mixer blades, pump bodies for abrasive materials, excavator teeth, crashing installations for minerals, concrete pumps, ores crushing, ploughshares, lumps break, screw presses for bricks

All Weld Metal Mechanical Properties

Hardness 1st layer	Hardness all weld metal
~ 58 HRC	~ 60 HRC

Mechanical characteristics of the deposited metal (%)

C	Si	Mn	Cr	Fe
3.3	1.0	0.5	29.0	Base

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0 x 450
Current	(A)	90	130	160

Other

Redrying 1h at 250°C, if necessary. Guide electrode almost vertically with a short arc. In case of hardfacing high alloyed steels like stainless steels, it is recommended to apply a cushion layer with HIGH SAFETY REPAIR ELECTRODES (853727 ; 853728 ; 853729)