ABRALOY 300

A highly alloyed low input anti-wear electrode for abrasion resistant overlays on carbon, low alloy, stainless and hadfield manganese steels. Deposits contain large volume fraction of carbides in a hard matrix. Smooth, dense and shiny weld deposits resists sliding wear.

Applications:
Dozer end bits, wear pads, cane knives, rubber mixing blades, end discs of bandury rotors, screw conveyors and dozer blades.

Procedure:
Preheat at 250º C for 1 hour before use. Gouge out/grind worn and fatigued metal. Use the electrode on AC/DC+. Hold short arc and deposit stringer beads. Use back-step, staggered welding sequence, chip slag between passes.

Technical Data

<table>
<thead>
<tr>
<th>Size (mm), Ø</th>
<th>ABRALOY 300</th>
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<tr>
<td>3.15</td>
<td>4.00</td>
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<td>5.00</td>
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Recommended Welding Current (Amps):

- 80–120
- 130 – 170
- 150 - 200

Hardness: 57 - 60 HRC.