

## ABRALOY 2412

ABRALOY 2412 is newly formulated heavy coated, high recovery electrode designed specially for severe abrasion resistance and mild to moderate impact. Alloy is easy to handle with rapid deposition rate leaving very little or no slag. The special alloy addition forms the carbides of different types. The fine distribution of vanadium carbides provides the weld deposit solid matrix which gives the abrasion resistance even at high temperature. A buffer layer of Diffusaloy 618 is recommended prior to surfacing on old claddings.

### Applications:

Mainly used on conveyor worms, clinker crushers, grates in mineral dressing equipment, concrete and cement pumps, Coal burner pipes, Fibrizer/Mincer hammers, Sinter breaker arms, Hot Slag Conveyors, Clinker Conveyor chains, Augers, Slurry pumps, Billet Conveyor Guides, Coke pusher shoes, vertical Coal mill rollers etc.

### Procedure:

- i Remove damaged, Oxidized and fatigued metal.
- ii Use AC/DC + Power sources.
- iii Maintained short to medium arc.
- iv Use stringer, slightly weave bead.
- v For high carbon steel base metal preheated to 250<sup>0</sup> C .  
Slow cool after welding.

<b><u>Technical Data</u></b>	:	<b>ABRALOY 2412</b>		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	95 - 130	135 – 170	165 –200
Hardness	:	60 – 65 HRC		
Tip Colour	:	Golden Brown		

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