ABRALOY 63

Newly formulated heavy coated high recovery electrode. Designed for extreme abrasion and mild impact conditions. The electrode has smooth running characteristics. Deposit consists of high % of primary chromium carbides nearly about 50 %.

Applications:

Surfacing of low alloy and mild steel under extreme abrasion and mild impact situation. Suitable for digger teeth, bucket edges, Muller tyres, Screw conveyors and Mixer parts, Sprockets, Pinions.

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 °C. Slow cool after welding.

Technical Data:

Size (mm), Ø : 3.15  4.00  5.00
Recommended Welding Current (Amps) : 90 - 120  120 – 170  160 – 200
Hardness : 57 – 63 HRC
Tip Colour : Golden Brown