ABROCAR 84

A low heat input “Anti-wear” iron-base alloy electrode for abrasion-resistant overlays on plain carbon and Hadfield manganese steels and Grey Cast irons. Deposits exhibit uniform distribution of carbides in a hard martensitic matrix for high hardness and superior resistance to low stress scratching and high stress scratching and high stress grinding abrasion.

Applications:

Bucket teeth, crusher mantles, pulverizer hammers, jaw crushers in mining, earthmoving and cement industry, plow shares, scrapers, road rippers, bucket lips, pug mill screws and fan blades.

Procedure:

1) Gouge out/grind, all worn, damaged and fatigued metal/cracks.
2) Use the electrode on AC/DC+ power source.
3) Employ lowest possible welding current. Skip and stagger weld.
4) Use stinger beads.
5) Chip slag between passes.
6) For multipass buildups and overlays, use cushion Layers of Tufaloy 320, Hadmoloy 140, Greloy 850 depending upon the base metal.

Technical Data

| Size (mm), Ø | 3.15 | 4.00 | 5.00 |
| Rec. Welding Current (Amps) | 80-110 | 110-150 | 150-200 |
| Hardness | 58-62 HRC |