

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		

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