

ABRALOY 300

A highly alloyed low input anti-wear electrode for abrasion resistant overlays on carbon, low alloy, stainless and hadfield manganese steels. Deposits contains 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 250° 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.

<u>Technical Data</u>	:	ABRALOY 300		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	80-120	130 – 170	150 - 200
Hardness	:	57 - 60 HRC.		

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