

**Applications**

Mine Rails & Crane wheels. Hot & Cold punching dies, metal cutting & forming tools. Crush hammers & caterpillars treads. Drilling bits, crane wheels, conveyor buckets. Oil expellers, shears & croppers.

**Characteristics on Usage**

A medium heavy coated Rutile type electrode, air hardening type of weld metal where approximately 600 Brinell hardness is required. Weld is non machineable and finished by grinding. The electrode is recommended for hard facing applications on mild steel, carbon steels & low alloy steels where severe conditions of abrasion, friction, accompanied by moderate impact exist. suitable for couplings, conveyor buckets, shears blades, steel castings, etc.

**Notes On Usage**

- 1) Dry the electrodes at 150°C for 60 minutes before use
- 2) Preheat the job at 150-200°C more than that in general.

**Welding Positions**

1G 2F

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Mo %	V %
0.40 – 0.70	0.20 – 0.40	0.2- 0.45	0.030 Max	0.030 Max	6.0– 7.8	0.50 – 0.80	0.4 – 0.7

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	5	20	11	44	70 - 100	AC / DC (+)
3.20 X 450	5	20	11	44	100 - 140	
4.00 X 450	5	20	11	44	140 - 180	
5.00 X 450	5	20	11	44	180 - 230	

HARDNESS ON IIIrd LAYER 600 BHN APPROX .