

LH 745 S Surfacing electrode with exceptional hardness and abrasion resistance

ALLOY BASIS

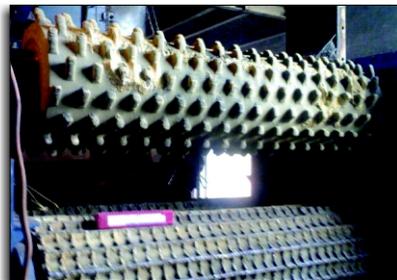
Fe, Cr, Cb, V, Mo, C

PROPERTIES

Hard surfacing electrode with excellent abrasion resistance at high temperature and has exceptional metal recovery (210%).

TECHNICAL DATA

Hardness : 57-63 RC
Hardness at 600 °C : 40-43 RC
Metal recovery : 190-210%



TYPICAL APPLICATIONS

For surfacing of hopper and protection plates in quarries, ore crushing rolls, gyratory crushers, ore breaker teeth, scraping beaks, sinter plant disintegrators, blast furnace bells and hoppers.

PROCEDURE

Hold medium arc. To prevent excessive dilution with parent metal use low current. The recommended hardness is obtained only on the second or third layer.

WELDING CURRENT

Current	: AC / DC (+)		
Size (∅ mm)/Length	: 3.2x350	4.0x350	5.0x350
Current (amps)	: 100-130	130-150	210-250



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