

LH 725

Surfacing electrode depositing chromium carbide

ALLOY BASIS

Fe, C, Cr

PROPERTIES

Weld deposit is extremely hard and wear resistant. "Chromium Carbide" is distributed uniformly in the weld matrix. Maximum two layers to be deposited for better results.

TECHNICAL DATA

Hardness : 60-65 RC

TYPICAL APPLICATIONS

Ideal for agitator blades, scrapper blades, conveyor screws, clay extruder screws. Coal crushers in thermal power plants, oil expeller worms, tooth points and buckets of excavators. Digger teeth, bucket tip edges, cement die rings, muller tyres, plough shears, crusher hammers in cement plant. For components subject to metal to metal wear and abrasion with mild impact likely to be absorbed elastically. Chinese long walls in underground mines. Surfacing of mild and low alloy steels for wear resistant properties.



PROCEDURE

Clean the affected area by wire brush. Hold the electrode at approx. 90° to the surface and deposit the weld beads. Chip the slag between passes. Maximum two layers are recommended.

WELDING CURRENT

Current	: AC / DC (+)		
Size (∅ mm)/Length	: 3.2x350	4.0x350	5.0x350
Current (amps)	: 100-130	110-140	140-180



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