

SPHF 043

Chromium-iron type highly alloyed electrode for good temperature and abrasion resistance

ALLOY BASIS

Fe, C, Cr

PROPERTIES

A heavy coated high alloy type electrode with smooth and forceful arc having superior weldability and very good compressive strength. Slag detaches easily leaving smooth, shining, uniform and glossy deposit. Distribution of chromium carbides in the matrix is uniform and even throughout weld metal. The deposit withstands temperature up to 650°C, mild impact and severe abrasion.

TECHNICAL DATA

Hardness : 57-60 RC

TYPICAL APPLICATIONS

For applications where combination of toughness and hardness is desired. Hard surfacing of parts which are subject to severe abrasive wear and moderate shocks. Conveyor worm screws, mixer blades, auger screws, dredging buckets, bells and hoppers, edge, runner bottom, etc.



PROCEDURE

- Make sure that the job is free from grease, oil, paint, dust, rust, etc., before welding.
- Maintain medium to short arc with 90° electrode inclination in the direction of travel.
- Remove slag with a stainless steel wire brush.

WELDING CURRENT

Current	:	AC / DC (+)		
Size (∅ mm)/Length	:	3.2x350	4.0x350	5.0x350
Current (amps)	:	110-145	130-180	140-200



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