

RUTILE BASED HARDFACING ELECTRODES



CHARACTERISTICS :

EURO HARD-300 is a rutile based, medium coated electrode which produces a hard layer of welding on mild steels, machinery parts, equipment accessories etc.,. The deposited weldment is tough and with machinable hardness of around 300 VPN. The weldmetal is resistant to rolling and sliding frictions and also exhibits excellent resistant to moderate to heavy impacts. The electrode produces a smooth and stable arc and it is easy to strike and re-strike in all positions.

ADVANTAGES :

- Uniform metal transfer with fine rippled bead.
- Easy to control weld pool and slag in position welding.
- Suitable for either polarity in DC (\pm) and in AC
- Smooth and stable arc

APPLICATIONS :

Euro Hard-300 is suitable for surfacing of hard layers on mild steel sections where resistance to friction and impact is necessary. The parts that can be hard surfaced include mild steels parts, carbon steel parts, low alloy parts, axles, gears, pulleys, wheels, shafts, couplings, rail-points and crossings, sugarcane crushers, pinion teeth, sprockets, rollers, tractor parts, railway tram cars rails, excavator equipment and parts etc.,.

CURRENT CONDITIONS AND PACKING DETAILS :

SIZE mm		3.15 X 450	4.00 X 450	5.00 X 450
CURRENT- Amps	AC 70 /DC(\pm)	90-120	130-160	160-200

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	%C	%Mn	%Si	%Cr
percent	0.20	0.60	0.40	1.80

TYPICAL HARDNESS VALUES : 300 VPN on III layer on mild steels.

PRECAUTIONS :

- Use short arc or use touch welding technique.
- Use proper current

PRE-HEATING RECOMMENDATIONS : If the base plate thickness is found to be high alongwith high Carbon content, preheating of the base plate will be required at 250°C and cool the base metal very slowly after welding.