

**RUTILE BASED AIR HARDENING TYPE
HARDFACING ELECTRODES**



CHARACTERISTICS :

EURO HARD-500 is a rutile based, medium heavy coated electrode which deposits a hard and wear-resistant layer on mild steels, machinery parts, equipment accessories etc., The deposited weldment is moderately resistant to impact, air hardening type and is an alloy of Carbon-Chrome-Moly. The weld deposit is machinable by carbide tools. 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
- Sound, Hard and wear & abrasion resisting deposit

APPLICATIONS :

Euro Hard-500 is suitable for surfacing of hard layers on mild steel sections where resistance to abrasion, wear and moderate impact is necessary. The parts that can be hard surfaced include brake shoes, crane wheels, wobblers, cams, gears, shafts, chain sheaves, dies, shares, conveyor parts, sprockets, shear blades, rail ends & crossings, pulleys, idler wheels, 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 | %Mo | %Cr |
|---------|------|------|------|------|------|
| percent | 0.20 | 0.60 | 0.40 | 0.50 | 3.20 |

TYPICAL HARDNESS VALUES : 400 VPN on III layer on mild steels.

PRECAUTIONS :

- Use short arc or use touch welding technique.
- Use proper current
- Rebaking at 100°C for one hour is required if the electrodes are found to contain moisture.
- Preheating is required depending on the thickness and type of material being welded.
- Uniform and slow cooling is required after welding.