

RUTILE BASED HARDFACING ELECTRODE

EURO HARD- V LH

CHARACTERISTICS :

EURO HARD-V LH is a rutile based, medium coated hard facing electrode with pleasing operating characteristics like smooth and stable arc, easy arc striking and re-striking properties, maneuverability in welding positions. The electrode deposits a non-machinable weld metal with C-Cr-Mo-V-W alloy which is highly resistance to severe abrasion , wear and moderate impact.

ADVANTAGES :

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

APPLICATIONS :

Euro Hard-vI LH is suitable for surfacing of hard layers on mild steel sections where resistance to server wear, abrasion and impact are necessary. The parts that can be welded/surfaced are machine parts & tools,oil expeller worms, plough shares, dredger buckets & cutters, excavator teeth, conveyors & buckets, earth moving equipment and parts, bulldozer blades, turnions, coke machinery, crusher jaws, coal crusher rolls, dipper teeth, hot punching tools, hot shear blades, well drill bits, muller blades, mill hammers, grader blades, crane shoes & crane hooks, building up of machinery parts and tools 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)	100-130	150-180	190-210

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	%C	%Mn	%Si	%Cr	%Mo	%V	%W
percent	0.50	0.60	0.45	7.20	1.30	0.40	0.25

TYPICAL HARDNESS VALUES : 650 VPn on III layer on mild steel.

PRECAUTIONS :

- Use short arc or use touch welding technique.
- Use lower current with smaller beads.
- Base metal should be clean, free of dirt, oil, grease, rust etc.,