

**GRAPHITE BASED HARD FACING ELECTRODES
FOR WORN OUT MACHINE PARTS**



CHARACTERISTICS:

EURO HARD V is a medium heavy coated electrode depositing hard and non-machinable chromium carbide alloy possessing hardness around 600VPN on 2nd layer on mild steel. Weld metal possesses excellent resistance to severe abrasion and wear under moderate impact. Electrode is easy to operate on AC as well as DC(+).

USES:

Typical applications of **EURO HARD V** include oil expeller worms, dipper teeth, excavator teeth, cement die rings, screw conveyor, muller tyers and ploughs, dredger buckets, crane wheels, working edges of earth moving equipments etc.

NOTED FEATURES:

1. Hard and non-machinable welds with excellent resistance to abrasion and wear.
2. Very well suited for filling up worn out machine parts.
3. Easy to operate on AC as well as DC(+).
4. Smooth and stable arc. Easy to strike and restrike.
5. Low spatter, uniform bead and easily removable slag.

CURRENT CONDITIONS:

SIZE mm		3.15 X 350	4.00 X 450	5.00 X 450
CURRENT- Amps	AC 70/DC(+)	100-140	140-170	170-210

CHEMICAL ANALYSIS OF THE WELD METAL:

Element	C	Mn	Cr
%	2.0 to 2.50	2.0max	5.0 max

HARDNESS DATA(VPN):

On mild steel

1st Layer : 530 to 550
2nd Layer : 570 to 600

SPECIAL INSTRUCTIONS:

1. Redry electrodes at 250°C for one hour before use.
2. Use minimum current and maintain shorter arc to avoid excess heat input.
3. Make stringer welds, avoid weaving and keep slow welding speed.
4. To avoid cracking of welds, deposit only two layers of this weld metal on worn out parts.
5. For carbon steels, use our EURO LH for building up worn out area followed by two final layers of EURO HARD V.
6. Preheating upto 250°C is also recommended for carbon steels followed by very slow cooling.