



MODI - 650 HARD SURFACING ELECTRODE

CHARACTERISTICS : A basic coated hard surfacing electrode having good welding characteristics even on AC. The electrode is highly resistant to cracking and exhibits excellent resistance to tempering upto 500°C. Its special characteristic is that, hardness of 550-600 Brinell is achieved in the first layer itself with a completely crack free deposit.

APPLICATIONS :

- * Cane Cutting Knives
- * Bamboo Chipper Knives
- * Disintegrater Hammers
- * Oil Expellor Worms
- * Crusher jaws
- * Mine Rails
- * Conveyor Buckets

RECOMMENDATIONS : Redry the electrodes at 350°C to 400°C for one hour or 250°C for two hours. Keep the redried electrodes in holding oven having 50°C to 60°C temperature. Use electrode directly from this holding oven. For thick deposits on austenitic manganese steel components, Modi Mn electrodes should be used for buffer layers.

CHEMICAL ANALYSIS OF WELD-METAL (%) :	C	Mn	Si	Cr	Mo
	0.5-0.8	1.0-1.4	0.6 max	6.5-7.5	0.40-0.80

HARDNESS : On single & multi layers deposit : 550-650 BHN

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	3.15x350	4.0x450	5.0x450
Amps	100-140	140-180	180-230



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