



MODI XL 650

HARD FACING 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 550-650 Brinell is achieved in the first layer itself with a completely crack free deposit.

APPLICATIONS :

- Crane Cutting Knives
- Bamboo Chipper Knives
- Disintegrator Hammers
- Oil Expellor Worms
- Crusher Jaws
- Mine Rails
- Conveyor Buckets
- Crane Wheels

RECOMMENDATIONS : Re-dry the electrodes at 350°C for one hour or 250°C for two hours. Keep the re-dried electrodes in holding oven having 50°-60°C temperature. Use electrodes directly from this holding oven. Use stringer bead technique. Maintain short arc.

CHEMICAL ANALYSIS OF WELD METAL (%) (TYPICAL) :

C	Mn	Si	Cr	Mo
0.6	1.1	0.66	7.3	0.45

HARDNESS : ON SINGLE & MULTI LAYER DEPOSIT : 550-560 BHN

CURRENT CONDITIONS : USE AC (50V) OR DC (+)

Size (mm)	3.15 X 450	4.0 X 450	5.0 X 450
Range (Amps.)	100-140	140-180	180-230



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Manufactured under licence from :
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