



# SUPER HARD ALLOY

## HARD SURFACING ELECTRODE

**CHARACTERISTICS :** A special electrode with basic type of coating designed for surfacing of parts subjected to heavy abrasion. Arc is very stable and smooth which ensures proper alloy transfer to weld deposit. Weld beads are flat and smooth. Slag is easily detachable. Performance is equally good on AC as well as DC (+)

**APPLICATIONS :**

* Excavator Teeth	* Plough Shares
* Oil Expellor Worms	* Cranes Wheels
* Crushing Hammers	* Cams
* Muller Tyres	* Cement Die Rings

**RECOMMENDATIONS :** To get optimum results re-dry electrodes at 350°C for one hour or at 250°C for two hours. Use stringer bead technique and sequence welding to control the rate of cooling. Use short arc and lower currents of the recommended range.

**CHEMICAL ANALYSIS OF WELD-METAL (%) :**

C	Mn	Si	Cr
2.0-3.0	0.8-1.25	2.0-3.5	3.5-5.5

**HARDNESS :** On three layers deposit : 525-600 BHN

**CURRENT CONDITIONS : USE AC OR DC (-)**

Size (mm)	3.15x350 3.15x450	4.0x450	5.0x450
Amps	100-130	140-180	190-230



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