

**Application/properties:**

Thick basic-covered electrode is suitable for wear-resistant layer on medium-hard parts. The weld metal has relatively good machinability or chip removal properties. The weld metal is resistant to cracking and porosity. This electrode is suitable for welding parts subject to impact sliding wear.

Weld metal analysis in % (typical values):

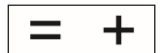
C	Mn	Si	Cr	Mo
۰.۳	۰.۸	۰.۹	۳	۰.۱

**Mechanical Properties of all-weld metal:
(single values are typical values)****Hardness as-welding**

۳۸ - ۴۲ HRC

Welding Parameters

Diameter (mm)	Length (mm)	Amperage (A)
۳.۲۵	۴۵۰	۱۰۵ - ۱۳۵
۴.۰	۴۵۰	۱۲۰ - ۱۸۰
۵.۰	۴۵۰	۱۷۰ - ۲۴۰

**Materials:**

Hard facing and repair of rail surfaces and switch pointer, screw conveyors, wheel flanges and the outer surface of pulleys, rollers and wheels.

Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ۳۰۰°C to ۳۵۰°C for ۲ hours.