

ABRADUR 3605

Description:

Newly formulated high recovery electrode having Chromium Carbides designed specially to resist high temperature abrasion and impact severe erosion on carbon steels and austenitic manganese steels. Alloy also resist moderate impact, high deposition efficiency i.e. 140%.

Applications:

Fibrizer / Mincer hammers, sinter breakers arms, hot slag conveyors, chains augers, slurry pumps, billet conveyor guides and coke pusher shoes.

Deposits consists of high percentage of primary and secondary carbides for optimum results. Hardness is retained upto 600°C.

Procedure:

Remove damaged, oxidized and fatigued metal. Maintain short to medium arc, deposit stringer or slightly weave beads. Backfill crater. For high carbon steel base metal preheat to 250 °C. For higher build up on carbon or high alloy steels use Uniloy 624 as cushion layer. For manganese steels, restrict heat buildup to 150 °C and if necessary use Hadmoly 140 or Xaloy 52 or Tufaloy 600X as cushion layer. Slow cool after welding.

TECHNICAL DATA	:	ABRADUR 3605		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	120 – 150	150 – 200	170 - 225
Hardness	:	62 - 64 HRC		
Tip Colour	:	Dark Grey		

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