

ABRALOY 61

Newly formulated heavy coated, high recovery electrode designed specially for extreme abrasion resistance at high temperature. Deposits consist of high percentage of primary chromium carbide and secondary Niobium carbides for optimum results. Hardness is retained up to 500 ° C. Alloy is easy to handle with rapid deposition rate leaving very little or no slag.

Applications:

ABRALOY 61 is used for hardfacing of parts subject to strong abrasive wear, friction, heat and corrosion. Hardfacing on tools used in steel, coal and ore mining as well as in the cement industry.

Procedure:

- i Remove damaged, Oxidized and fatigued metal.
- ii Use AC/DC + Power sources.
- iii Maintained short to medium arc.
- iv Use stringer , slightly weave bead.
- v For high carbon steel base metal preheated to 250 ° C .
Slow cool after welding.

<u>Technical Data</u>	:	ABRALOY 61		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	95 - 130	135 – 180	160 –200
Hardness	:	60 – 65 HRC		
Tip Colour	:	Golden Brown		

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