

CARBALOY 10

SUPERIOR HIGH ALLOY ELECTRODE WITH EXCELLENT ABRASION AND GOOD IMPACT RESISTANCE. HIGH DEPOSITION RATE.

AC OR DC REVERSE POLARITY (ELECTRODE+)

GENERAL CHARACTERISTICS:

Carbaloy 10 is designed for use on carbon and low alloy steels, manganese steels, and cast iron. Deposits take a high polish, which contributes to high frictional and abrasion wear qualities, especially small particle abrasion. Excellent on applications that need impact as well as abrasion resistance. Provides optimum resistance to this combination. Deposits well out of position.

APPLICATIONS:

Carbaloy 10 is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1,000°F. Especially designed for crusher applications. Used heavily in construction, mining, brick and clay industries on parts such as crusher rolls, jaw crushers, bucket teeth, edges, hammers, mill hammers, conveyor screws, etc.

TECHNICAL DATA:

HardnessRc 56-64
Current AC or DC reverse polarity (electrode+)
Amperage 80-125 100-160 125-190
(in) 1/8" 5/32" 3/16"
(mm) 3.25 4.0 5.0

PROCEDURE:

Remove any fatigued or unsound metal with Chamfertrode. According to the thickness of deposit and type of base metal, a padding a 747Wh, Carbaloy 8, or 747Ultra might be considered. On cast iron, a base of Castex 9 is recommended. Deposits can be applied as stringer beads; however, weave passes are recommended for maximum deposition rate. Prevent excessive heat build-up. Allow parts to cool slowly. Up to 2 passes only.