

CARBALOY 65

ELECTRODE FOR HIGH ABRASION AT ELEVATED TEMPERATURES 65 HRC

AC OR DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

Smooth running electrode composed of Chromium, Tungsten, Molybdenum, and Columbium. It produces a flat weld with a very high deposition rate. Deposits are highly resistant to abrasion and erosion, even at elevated temperatures, up to 1600°F. Stable arc when using alternating current. Clearly visible metal pool, minimal slag. The 240% deposition rate ensures economic welding.

APPLICATIONS:

Wear and abrasion resistant welds for hard surfacing machine components subject to extremely high abrasion by sand, gravel, ore, coal, cement, slag, etc. Due to high abrasion resistance at elevated temperatures, this electrode is also suitable for hardfacings on crushers, grates, conveyors for hot (glowing) coke, slag, cement, and sinter-handling equipment.

TECHNICAL DATA:

Hardness as welded64-70 Rc

Current AC or DC reverse (electrode+)

Amperage 140-170 180-220 230-300

(in) 1/8" 5/32" 3/16"

(mm) 3.25 4.0 5.0

PROCEDURE:

Remove all foreign material from weld area. Welding should be done in either the flat or horizontal position. Crack sensitive material must be preheated to 750°-930°F (400°-500°C). Slag can be over-welded. Medium build-up is possible at high current load. Do not deposit more than three layers on top of each other. In the case of thick hard facings fill beforehand, with Carbaloy 5 or Carbaloy 8 for example.

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EXTREME DUTY CARBALOY 65