



ADOR AS

HARD FACING (Build Up)



Hardfacing Electrode for Resistance against Sliding Abrasion

ALLOY BASIS :

Low Carbon Manganese Alloy

KEY FEATURES :

- Basic coated electrode
- Good machinability
- Tough weld metal can withstand hard blows
- Suitable for medium hardness hardfacing with high resistance to abrasion by sliding and rolling action

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Hardfacing on rails, joints & rail crossing with a tensile strength upto 900 Mpa
- Wheels, Track surfaces, Pulleys
- Crane tracks, Gear components
- Suitable for build up applications

REDRYING CONDITION : 250-300°C for minimum 1 hr.

PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRc (BHN)
As Welded	30-35 (275-325)

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 350	100-140	5	4	20
4.0 x 350	150-200	5	4	20
5.0 x 350	200-260	5	4	20

Physical Properties: With increase in number of squares, property improves