

Hardfacing SMAW Electrode

HARD D

Metal to Sand abrasion resistant

Product Features:

- Less spatter loss, few slag and high welding performance.
- Suitable for all positions.
- Chromium carbide and Chromium boride contained in weld metal to get even hardness and good wear resistance at elevated high temperature condition.

Applications:

- Suitable for metal-to-hard soil abrasion worn out machine parts such as propeller blade and agitator blade.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Cr	Mo + Others
2.33	1.23	0.54	4.050	≤2.000

Typical hardness of weld metal

As welded HRC	layers
60	3

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/350	4.8/350	5.0/450
Flat / position	100~140	140~190	170~220	180~230

Note:

- 100~160°C x 1 hr baking prior to use.
- Max. 3 layers.
- Typical stress crack occurred to prevent peeling damage between base and weld metal.

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