

Metal to sand abrasion resistant

HARD 31

Product Features:

- Covered electrode, chromium carbide precipitation in austenite weld metal.
- Weld metal contains special alloy elements to get good corrosion and elevated high temperature abrasion resistance.
- Good bead appearance, very low friction coefficient in weld metal surface.
- Good for moderate impact and severe wear condition.

Applications:

- Suitable for hardfacing repair welding of agitator blade, metallic sieve, shovels teeth and agricultural tools, etc.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo
2.40	0.60	0.60	27.3	1.3

Typical hardness of weld metal

Carbon steel HRC	Manganese steel HRC	layers
47	46	3

Size (mm) & recommended welding parameters (A)

Diameter / Length	3.2/350	4.0/350	4.8/350	6.4/350
Flat position	80~120	140~170	180~230	230~280

Note:

- 200~250°C x 1 hr baking prior to use.
- Max. 3 layers.