

ULTRA HARD FACING 500

FLUX CORED WIRE

Hardfacing Wire for Severe Abrasion & Moderate Impact

CLASSIFICATION:

- Hardfacing Wire
- Self Shielded / Gas Shielded
- Deposit Hardness: ~ 48 – 55 HRC
- Suitable for single & multi-layer build-up

TYPICAL APPLICATIONS:

- Bucket edges & lips
- Conveyor screws
- Crusher components
- Mixing paddles
- Bulldozer & loader blades

KEY FEATURES:

- Excellent resistance to severe abrasion
- Good hardness and wear resistance
- High deposition rate
- Uniform bead appearance
- Smooth arc characteristics

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 0.45	Mn – 0.8	Si – 0.6	Cr – 5.5	Fe – Bal	
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MECHANICAL PROPERTIES OF WELD METAL:

Hardness (HRC)	Impact Resistance	Abrasion Resistance
48–55	Moderate	High

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	160-280
1.6	200–340

DCEP(Electrode Positive)

When using mix shielding gas..

Available in 15 kg vacuum pack wound on plastic spool.



DCEP

Electrode Positive

All positions except vertical down



Use 1-2 volts lower when using mix shielding gas