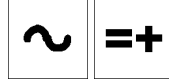


Coating type:

Basic

Arc voltage: 65V

Current:



Tip colour:

Red

Welding positions:



Printing:

HARDMELT 600

Hardmelt 600 is our basic coated electrode for wear resistant surfacing parts of steel, cast steel and high Mn-steel, subject to abrasion, metal-to-metal wear, impact and/or compression stresses. Deposit weld metal has a martensitic structure, hardness of pure weld deposit approx. 600HB. After welding the deposit can be machined by grinding only.

Applications:

Hardmelt 600 is particularly suitable under conditions of heavy abrasion and friction, combined with impact. Ideally suitable for applications involving rolling, sliding and metal-to-metal wear.

Applications are universal but typical for hardfacing parts e.g. agricultural, earth moving and stone crushing industry, hardfacing crane and mine car wheels, sprockets and gear teeth, skip guides, dredger buckets, scrapper blades, transferables, cable sheaves, tractor and shovel parts, dragline buckets, conveyor chains, hammer heads, clutch jaws

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	H600	Hilcord 600	-	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,50	0,40	2,30			9,0						

Mechanical properties, weld metal – typical:

Condition	Hardness
As welded	1 layer After soft annealing 780-820°C / oven After hardening 1000-1050°C / oil 1 layer on high Mn-steel 2 layer on high Mn-steel
	56-58 HRc approx. 25 HRc approx. 60 HRc approx. 22 HRc approx. 40 HRc

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	34,6	100-140
4,0	450	65,6	140-180
5,0	450	105,5	180-210