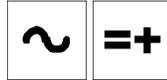


**Coating type:**

Basic

**Arc voltage:** 60V

**Current:**



**Tip colour:**

-

**Welding positions:**



**Printing:**

HARDMELT 638

Hardmelt 638 is our basic coated high efficiency (205%) electrode for wear resistant surfacing parts subject to grinding abrasion and moderate impact. Deposit weld metal is a near eutectic mix of chromium carbides and austenite, hardness of pure weld metal is 60 HRc. After welding the deposit can be machined by grinding, due to the homogeneous and finely rippled seam this is, for most applications, not necessary.

**Applications:**

Hardmelt 638 produces an abrasion resistant deposit and is particularly suitable for applications involving grinding abrasion with moderate impact at service temperatures up to 600°C. The weld deposit is extreme resistant to mineral wear. Hardmelt 638 is also suited as a final layer on tough-hard deposits (Hardmelt 600) or high Mn-steel (Manganil).

Typical applications are found in heavy constructions, mining, stone crushing and dredging industries e.g. shovel and dragline buckets, bucket teeth, scraper cutters, scoop lift buckets, crusher hammers, cement mixers, dredge pump parts, rubber industry mixing machines, shaker pans, excavator buckets, gyratory and impact crusher parts, conveyor screws

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	-

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	W
5,20	0,50	1,60			31,8						

**Mechanical properties, weld metal – typical:**

Condition	Hardness
As welded	1 layer 1 layer on steel with C = 0,15% 1 layer on high Mn-steel
	60 HRc approx. 55 HRc approx. 52 HRc

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	53,5	110-140