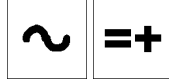


Coating type:

Basic

Arc voltage: 45V

Current:



Tip colour:

-

Welding positions:



Printing:

HARDMELT 645

Hardmelt 645 is our basic coated high efficiency (250%) electrode for wear resistant surfacing parts subject to severe abrasion and moderate impact. Deposit weld metal has a premium carbide structure with Nb, Cr, Mo, W and V carbides; hardness of pure weld metal is 63 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 645 produces an abrasion resistant deposit and is particularly suitable for applications involving severe sliding mineral abrasion with moderate impact at service temperatures up to 600°C.

Typical applications are found in cement and steel industries e.g. hardfacing excavator teeth, bag packer screws, pulverizer mill components, spreader cones, conveyor and mixer screws, fan blades, shredder knives, dredge pumps parts, sintering plant parts, wear bars and plates, scraper bars, blast furnace, cement furnaces, bucket teeth and lips

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
5,80	1,50	1,90			21,0		6,0		6,0	1,2	2,5

Mechanical properties, weld metal – typical:

Condition	Hardness	
As welded	1 layer	63 HRc
	1 layer on steel with C = 0,15%	approx. 58 HRc
	1 layer on high Mn-steel	approx. 55 HRc

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
4,0	450	131,6	140-190