


<b>HR-6600</b>	<b>LIME RUTILE HARDFACING ELECTRODE    DEPOSITING WELD METAL HIGH IN CHROME    CARBIDE PROVIDING EXCELLENT RESISTANCE TO    ABRASION</b>			<b>DATA SHEET    NO.    124</b>							
SPECIFICATION	DIN 8555 E10-UM-65-G										
CLASSIFICATION											
PRODUCT DESCRIPTION	<p>The design emphasis of the flux is designed to ensure a slag solidification range that allows the chrome carbide particles to be evenly distributed within the austenitic alloy matrix, so ensuring complete uniformity of hardness.</p> <p>The balanced lime rutile flux contains the appropriate alloying elements and is bound with a blend of silicates that ensures both coating strength and resistance to moisture absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>The electrode welds with a smooth stable arc and easily strikes and re-strikes. Weld appearance is bright, almost of polished appearance, smoothly contoured and slag detachability is excellent.</p> <p>The metal recovery is some 170% with respect to core wire weights, thus reducing welding time. The weld deposits are non-machinable.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Suitable for surfacing a wide range of steels including 13Mn types. Because thermal contractional stresses will cause stress relieving cross-cracking, build-ups should be limited to 3 layers, preferably two when restraint is high.</p> <p>The deposit has excellent resistance to abrasion against minerals, sand and sludges which leads to its extensive use in the earth moving, cement, dredging and steel industries.</p> <p>For build-ups on carbon and low alloy steels or 13Mn steel NSB-307, should be used as a buffer layer.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	V	Fe
	MIN.	4.5	-	-	-	-	55	-	-	-	
	MAX.	5.5	1.0	2.0	0.02	0.02	65	1.0	1.0	1.0	
	TYPICAL	5.0	0.22	1.0	0.001	0.003	60	0.05	0.03	0.02	Bal.
WELD METAL HARDNESS (ALL WELD METAL)	AS WELDED 150°C PRE-HEAT		HRC				HV				
	1 <sup>st</sup> Layer		48 – 54				475 – 575				
	2 <sup>nd</sup> Layer		56 – 62				675 – 700				
	3 <sup>rd</sup> Layer		60 – 66				700 – 850				
Actual hardness will be affected on base material composition, number of layers, heat input and welding conditions											
WELDING AMPERAGE AC or DC+	Ø (mm)		3.2		4.0		5.0				
	MIN		110		150		190				
	MAX		160		220		270				
											
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.										
RELATED PRODUCTS	Please contact our Technical Department for detail.										