



SUPERGOLD 700 GCM

**For abrasion resistance and moderate
Impact resistance**

- Basic coated SMAW electrode for hard surfacing, hardness 60-65 HRC.
- Good for severe abrasion and moderate impact resistance.
- Suitable up to 500°C.
- 120% Recovery.
- Low co-efficient of friction.
- Low-heat input smooth arc transfer.
- Excellent weldability.

Typical mechanical properties:

Undiluted Weld Metal

Structure

Hardness

Wear Coefficient

Machinability

Maximum Value Up to:

Martensitic cast iron

1st layer 60 HRC

2nd layer 62-64 HRC

3rd 63-65 HRC

2% (SiO₂ as abrasive)

Grinding only

Recommended current:

DC Straight(-), AC

Recommended amperage settings:

Diameter (mm)	3.15	4.00	5.00
Minimum Amperage	85	115	150
Maximum Amperage	120	150	190

Welding positions:

Flat, Horizontal, Half up

Welding techniques:

Select the minimum required amperage and utilize a medium arc gap. For smooth flat welds use a 3 X weave. There is minimal slag which can be over welded without prior removal. Only 2 passes are required for development of the full benefits of this alloy. Cross crack stress relieving is normal.

Applications:

For excavator parts, bucket edges & bucket teeth, drilling bits, coal planes, crusher jaws & cones, conveyor screws, mixer blades, pump and crusher parts, operation in sand, clay, cement, and coal.....