



Superon Superhard 650 Hardfacing

Hardfacing electrode resistant to impact,
compressive and abrasion

Description and applications:

Rutile-basic coated general purpose hardfacing electrode for applications subject to impact, compression and abrasive wear. For hardfacing on components made of C-steel, cast steel and manganese steel. The deposit is tough-hard and crack-resistant.

Special applications are: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc.

All weld metal mechanical properties:

Hardness
58-60 HRC

Obtained in pure weld metal

Recommended current:

DC Reverse(+) or AC

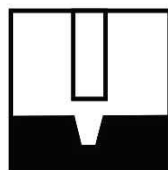
Recommended amperage settings:

Diameter (mm)	3.15	4.00
Minimum Amperage	90	120
Maximum Amperage	130	160

Welding instructions:

Guide electrode almost vertically with a short arc. On materials sensitive to cracks use of buffer-layer of ferrowork NiMnCr is recommended. Low alloyed, high carbon tool steels etc, have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

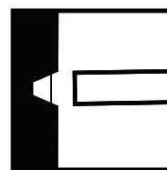
Welding positions:



1G/PA



2F/PB



2G/PC