



NEXA-7072

ELECTRODE FOR TOUGH AND WEAR- RESISTANT SURFACING ALLOY DEPOSIT

ALLOY BASE : Fe, Cr, Mn, C

SPECIAL FEATURES

- Basic all position electrode.
- The deposit is particularly resistant to impact.
- Thick surfacing without intermediate layers possible

RECOMMENDATIONS

For overlaying parts subject to friction and impact. Can be used for multipass buildup in all position. Best suited for reclamation of steel rollers in rolling mills.

APPLICATIONS

Surfacing of parts subject to wear or impact, rims, carbon-alloyed rails dies, striking tools, rolling surfaces, sliding surfaces subject to heavy wear, matrixes, stampers, etc.

PROCEDURES

Clean the surface thoroughly. Remove all cracked and spelled metal. Use short arc and lay stringer bead. Weld 2-3 layers. Finish welds metal by machining.

TECHNICAL DATA

Hardness : 29-35 HRc

CURRENT RANGE (AC/DC+)

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	80-110	110-160	140-180