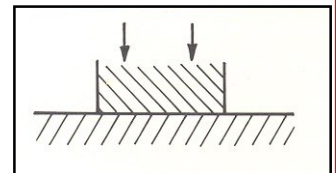




ARCWEL 300- SMAW — ANTI IMPACT ALLOY

Hardness : HB 250-350 EN 14700– E Fe 1

- All position general purpose hard facing alloy for heavy build ups and overlays which must **resist impact ,pressure and moderate abrasion**
- The deposit is tough– semi hard and can be machined,
- **Typical applications are repair and build ups mill hammers, forging & drawing dies, crane & rail -wheels , sprockets, gear teeth, cone crushers , press molds etc.**
- Multi pass build up possible without cracks. Heat treatable deposit
- All position weld ability-Easy striking almost spatter free welding
- for use on steel, manganese steel, and malleable iron
- Resistant to medium friction and high compression



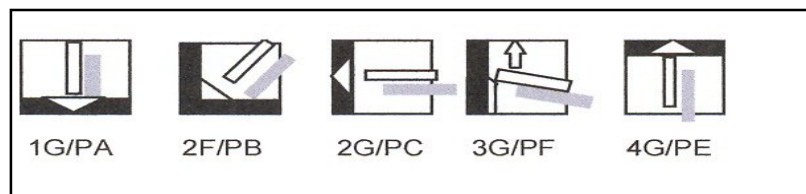
ANTI IMPACT

Typical weld metal composition (%) SMAW

C	Si	Mn	Cr	Mo	Ni	Fe
0.08-0.12	0.4-0.8	0.8-2.	0.8-3.0	0.3-1.2	0.4--3.2	Bal

Packaging Data	Sizes	3.2x350	4.0x450	5.0x450
	Kg /Packet	5	5	5
SMAW	Packets/carton	4	4	4
	Kgs/carton	18	20	20

Welding in- structions	Current (A)	80-110	110-140	140-180



= +,- ~ 70V

Note: similar alloys in wire form are available for GMAW , FCAW, GTAW & ARCSpray (AS) Processes. Please send us your enquiry .

Disclaimer:The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties.

Arcwel reserves the right to alter specification without further notice. **Health & Safety :**

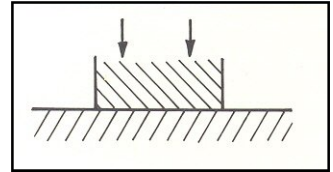
Observe safety regulations (fumes) MSDS available on request www.arcwel.com E-mail : info@arcwel.at



ARCWEL 600-SMAW FOR IMPACT & PRESSURE

HARDNESS : HB ~600 HRC 56-60 EN 14700—E Fe 2

- ◆ All position general purpose **hard facing electrode** for overlays which must **resist impact , pressure and moderate abrasion**
- ◆ The deposit is tough hard and can also be used with one or two layers of **630 or 650** on top when high abrasion resistance is required
- ◆ **Used for protection of bucket edges, crusher rollers, sugar cane shredder & mill hammers, cams, bulldozer blades, cutting edges, screw conveyors for plastic processing, grab jaws, ripper teeth, chisels ,press molds, tamping bar hammers (railway) etc.**
- ◆ Multi pass build up possible without cracks. Heat treatable deposit
- ◆ All position weld ability
- ◆ for use on steel, manganese steel, and malleable iron



Impact resistant

HARDNESS (AW) : HB ~600 obtained in 2– 3 layers

Typical weld metal composition %

C	Si	Mn	Cr	V	Mo	Fe
1-2	0.5-1.0	1-2	4-6	<0.3	<0.5	Base

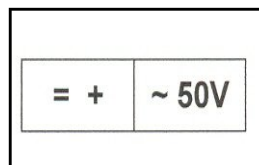
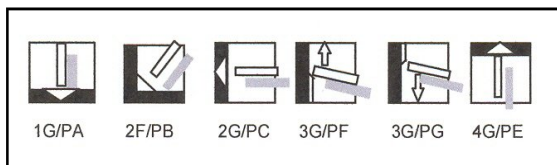


Bucket protection

Packaging and Welding Data

Sizes	3.2x450	4.0x450
Kg /Packet	6.5	6.5
Rods per Packet		
Packets/carton	4	4
Kgs/carton	26	26

Current (A)	135	160



For mill hammer hardfacing

Similar Products are available in solid Wire for GTAW /GMAW or as flux cored wire for FCAW Welding . Datasheet available on request

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MSDS available on request. www.arcwel.com E-mail : info@arcwel.at