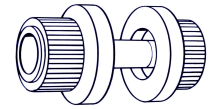


SHUBER E 725

MACHINABLE WEARFACING - HEAVY IMPACT



DESCRIPTION

MACHINABLE SURFACING ELECTRODE FOR OVERLAYS ON FERROUS PARTS SUBJECTED TO HEAVY SHOCK LOADING AND MILD ABRASION. Excellent also for cushioning hard surfacing applications. Designed for sprockets, rollers, hammers, gears, shafts and excavator parts.

SPECIAL FEATURES

- High deposition rate.
- Superior resistance to deformation.
- Moderate hardness and easily machinable.

APPLICATION INSTRUCTIONS

Clean weld area. Remove loose or fatigue metal by chamfering with SHUBER E 100 or by grinding. Preheat heavy sections to 100-150°C(200-300°F). Use stringer or weaving technique holding a short to medium arc. No danger of cracking in long deposits.

TECHNICAL DATA

HARDNESS: 28 - 32 RC

RECOMMENDED CURRENT:

AC or DC (Straight or Reverse Polarity)

DIAMETER AMPS

3.2 mm (1/8") 100 - 120

4.0 mm (5/32") 110 - 140

5.0 mm (3/16") 135 - 175

Tip Colour: Blue

DIN 8555:

E 1 - 350