

SHUBER E 740

WEARFACING - IMPACT AND ABRASION



DESCRIPTION

SURFACING ELECTRODE OF MEDIUM CHROMIUM ALLOY DESIGNED TO PRODUCE TOUGH AND MEDIUM HARD DEPOSITS WITH GOOD RESISTANCE TO A COMBINATION OF IMPACT AND ABRASION. High compressive strength makes it ideal build-up material as well as good underlay for hardfacing. Recommended for rebuilding of rollers, tractor pads, wobblers, rail ends & crossings, shear blades, forming dies, punches, brake drums and couplings.

SPECIAL FEATURES

- Rapid deposition and good running properties.
- Multi-pass build-ups without danger of cracking.
- Superior toughness & excellent resistance to deformation.

APPLICATION INSTRUCTIONS

Clean weld area. Remove loose or fatigue metal by chamfering with SHUBER E 100 or by grinding. Preheat to 220°C(425°F) may be necessary for heavy sections. Keep the arc as short as possible. No danger of cracking in long deposits. Slow cooling is recommended.

TECHNICAL DATA

HARDNESS: 34 - 46 RC

RECOMMENDED CURRENT:

AC or DC - (Straight Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	100 - 120
	4.0 mm (5/32")	120 - 140
	5.0 mm (3/16")	135 - 175

Tip Colour: Green

DIN 8555:
Fe E 1 - 400