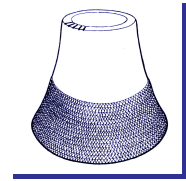


SHUBER E 750NM

WEARFACING - SEVERE IMPACT



DESCRIPTION

NICKEL ALLOYED MANGANESE STEEL ELECTRODE FOR JOINING AND BUILDING-UP SEGMENTS WHERE SEVERE IMPACT AND COMPRESSIVE FORCES ARE CONTINUALLY ENCOUNTERED. Weld deposit work-hardens in service and exhibit high resistance to cracking. Specifically developed for heavy construction and mining equipment overlays such as shovel rollers, dipper teeth & lips, crusher rolls, mill liners, crusher jaws, crusher hammers, manganese steel rails and switches.

SPECIAL FEATURES

- High resistance to compression & shock.
- Concentrated stresses hardens the surface while inside remains tough to withstand severe impact.
- Special synergistic elements prevent brittleness.

APPLICATION INSTRUCTIONS

Prepare weld surface by chamfering with SHUBER E 100 or by grinding to remove surface scale or remains of previous deposit. Weld at the lowest possible amperage and cool the workpiece at the same time. Keep interpass temperature low by skip-welding to avoid localized overheating. Deposit on austenitic manganese steel can be water-quenched to prevent heat build-up.

TECHNICAL DATA

TENSILE STRENGTH : 82 kg/mm² (115,000 psi)
HARDNESS: As Deposited - 85-90 HRB
Workhardened - 45-50 HRC

RECOMMENDED CURRENT: DIAMETER	AMPS
AC or DC + (Reverse Polarity)	
3.2 mm (1/8")	100 - 120
4.0 mm (5/32")	130 - 150
5.0 mm (3/16")	150 - 200

Tip Colour: White

DIN 8555:
E 7 - 250 K