

SHUBER E 755

HARD OVERLAY FOR STEELS & CAST IRON



DESCRIPTION

AN ECONOMICAL WEARFACING ELECTRODE THAT PRODUCES WEAR RESISTANT PROTECTIVE OVERLAYS CAPABLE OF WITHSTANDING HIGH IMPACT AND ABRASION. The electrode gives a clean, easily controlled deposit and can be used on carbon steels, alloy & tool steels, cast steel and cast iron. Applications include build-up of pile drivers, crushers, bucket teeth, mill hammers, cams, excavator parts and bulldozer blades.

SPECIAL FEATURES

- Outstanding weldability and high resistance to cracking even in long deposits.
- Superior multi-pass build-ups that resists combination of abrasive wear and impact.
- Ease of application and superior performance in all positions.

APPLICATION INSTRUCTIONS

Remove cracked or spalled metal to assure proper fusion. For deposits on alloyed steel, preheat to about 400°F. Use lowest amperage possible that will give proper fusion. Deposit either stringer beads or weave 2X electrode diameter holding a short to medium arc.

TECHNICAL DATA

HARDNESS: 50 - 55 RC

TYPICAL WELD METAL ANALYSIS:

Cr	C	Mn
4.50	0.50	1.50

RECOMMENDED CURRENT:

AC or DC (Straight or Reverse Polarity)

DIAMETER	AMPS
3.2 mm (1/8")	90 - 135
4.0 mm (5/32")	120 - 180
5.0 mm (3/16")	150 - 200

Tip Colour: Light Blue

DIN 8555
E 6 - 55r