

SHUBER E 760

WEARFACING - SEVERE ABRASION



DESCRIPTION

A CHROMIUM ALLOYED WEARFACING ELECTRODE DESIGNED FOR HARD OVERLAYS ON WEARING SURFACES AND EDGES EXPOSED TO SEVERE ABRASIVE WEAR AND MODERATE IMPACT. Applications include surfacing of scraper blades, buckets, tractor parts, shovel bucket lips, cement mill parts, screw conveyors, crusher hammers, excavator parts and other applications where abrasion is encountered.

SPECIAL FEATURES

- Rutile type coating gives easy manipulation, no undercutting & spatter.
- Superior multi-pass build-ups & superior performance in all positions.
- Excellent wear characteristics & low dilution of the base metal.

APPLICATION INSTRUCTIONS

Clean weld surface of all impurities such as oil and grease to avoid porosity. While preheat is not required on most applications, preheat to about 300°F will assist in starting weld on high carbon & alloyed steels. Use lowest amperage possible that will give proper fusion and employ weaving holding a short-to-medium arc. Cool slowly after welding.

TECHNICAL DATA

HARDNESS: 60 - 62 RC

RECOMMENDED CURRENT:

AC or DC - (Straight Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	100 - 110
	4.0 mm (5/32")	120 - 140
	5.0 mm (3/16")	160 - 180

Tip Colour: Red

DIN 8555
E Fe 6-60