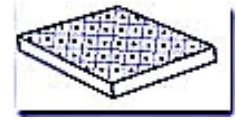


SHUBER E 762

WEARFACING - FRICTIONAL ABRASION



DESCRIPTION

HIGHLY ALLOYED WEARFACING ELECTRODE THAT PRODUCES PROTECTIVE OVERLAYS DESIGNED FOR FRICTIONAL AND ABRASIVE APPLICATIONS. High percentage of chromium carbide in the weld metal provides superior resistance to mineral abrasion. The high chromium content exhibits good corrosion and heat resistance up to 1000°C. Ideal for hardsurfacing details in mining and mineral industry, concrete pump parts, mixer blades, conveyor screws, excavator blades, crushing mills, agitator components, edge runners and chutes.

SPECIAL FEATURES

- High hardness at elevated temperatures.
- Superior weldability and high deposition rate.
- Special coating minimizes base metal dilution.

APPLICATION INSTRUCTIONS

Prepare weld surface by chamfering with SHUBER E-100 or by grinding to remove cracked or spalled overlay deposits. Incline the electrode in the direction of travel and keep a medium arc length. Direct the arc on previously deposited weld metal and use medium-to-wide weaving technique. Deposition should be limited to 3 layers. Full properties are obtainable in two-layer deposits.

TECHNICAL DATA

HARDNESS: 58 - 62 RC

RECOMMENDED CURRENT:
AC or DC +(Reverse Polarity)

DIAMETER	AMPS
3.2 mm (1/8")	95 - 130
4.0 mm (5/32")	120 - 190
5.0 mm (3/16")	155 - 250

Tip Colour: Black

DIN 8555:
E 10 - 60Z