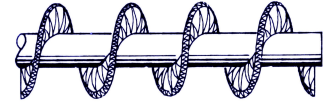


SHUBER E 765

WEARFACING - EXTREME ABRASION



DESCRIPTION

A TRULY UNIQUE ELECTRODE OF UNSURPASSED WELDABILITY DESIGNED TO PROVIDE PROTECTIVE OVERLAYS HIGHLY RESISTANT TO HEAVY ABRASION AND METAL-TO-METAL WEAR. High chromium-niobium-carbide rich deposit exhibit high resistance to erosive wear by fine grained minerals especially in corrosive or oxidizing environment. Recommended for hardsurfacing parts exposed to extreme abrasion such as scrapers, paddles, cement press screws, palmtut press screws, refractory press screws, augers and wear pads.

SPECIAL FEATURES

- Self lubricating action. Positively defies the most severe abrasion.
- Ease of application and high deposition rate (190 %).
- Retains hardness even at elevated temperatures.
- 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: 63 RC

RECOMMENDED CURRENT: DIAMETER AC or DC +(Reverse Polarity)	AMPS
3.2 mm (1/8")	100 - 140
4.0 mm (5/32")	140 - 190
5.0 mm (3/16")	180 - 275

Tip Colour: Yellow

DIN 8555:
(10 - 60Z)