

SHUBER E 768

ABRASION RESISTANCE AT HIGH TEMPERATURES



DESCRIPTION

NIOBIUM TYPE METAL-POWDER ELECTRODE DESIGNED FOR HARD PROTECTIVE OVERLAYS WITH EXCEPTIONAL RESISTANCE TO ABRASION AND FRICTION AT ELEVATED TEMPERATURES UP TO 700°C. Special alloying elements in combination with a grain refining agent in the electrode produces a deposit with a uniform distribution of several types of very small, wear resisting particles in an austenitic matrix. Ideal for parts subjected to heavy abrasion used in sinter crusher segments, conveyor screws, hot agglomeration fans, ash plows, scrapers in zinc industries, rake teeth in furnaces, slag laddles, bucket elevator tips and blast furnace hoppers.

SPECIAL FEATURES

- Retains hardness even at high temperatures.
- Superior weldability and high deposition rate (240 %).
- Special coating chemistry minimizes base metal dilution.

APPLICATION INSTRUCTIONS

Prepare weld surface by chamfering with SHUBER E 100 or by grinding to remove cracked or spalled metal. Hold the electrode vertical to the workpiece and keep a medium arc length. Direct the arc on previously deposited weld metal and weave slightly up to 3X electrode diameter. Full properties are obtainable in two-layer deposits.

TECHNICAL DATA

HARDNESS: 62 - 65 RC (two layers)

RECOMMENDED CURRENT: DIAMETER AC or DC +(Reverse Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	100 - 130
	4.0 mm (5/32")	130 - 190
	5.0 mm (3/16")	190 - 280

Tip Colour: Orange

DIN 8555:
(E10 - 65Z)