

ABROCAR 84

A low heat input "Anti-wear" iron-base alloy electrode for abrasion-resistant overlays on plain carbon and Hadfield manganese steels and Grey Cast irons. Deposits exhibit uniform distribution of carbides in a hard martensitic matrix for high hardness and superior resistance to low stress scratching and high stress scratching and high stress grinding abrasion.

Applications:

Bucket teeth, crusher mantles, pulverizer hammers, jaw crushers in mining, earthmoving and cement industry, plow shares, scrapers, road rippers, bucket lips, pug mill screws and fan blades.

Procedure:

- 1) Gouge out/grind, all worn, damaged and fatigued metal/cracks.
- 2) Use the electrode on AC/DC+ power source.
- 3) Employ lowest possible welding current. Skip and stagger weld.
- 4) Use stinger beads.
- 5) Chip slag between passes.
- 6) For multipass buildups and overlays, use cushion Layers of Tufaloy 320, Hadmoly 140, Greloy 850 depending upon the base metal.

<u>Technical Data</u>	:	ABROCAR 84		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	80-110	110 -150	150 - 200
Hardness	:	58-62 HRC		

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