

ARCTEC® 60 ECOFACE®



GENERAL CHARACTERISTICS:

ARCTEC® 60 ECOFACE® is an economical general hard surfacing alloy for build up and hard overlay applications. The weld deposit is dense and porosity free, and despite high hardness it has exceptional resistance to impact. The special coating makes it possible to use this electrode in all positions. Deposit is machinable by grinding only.

APPLICATIONS:

ARCTEC® 60 ECOFACE® is suitable for general build up and hard overlays on construction and mining equipment. Applications include surfacing of crusher rolls, bucket teeth and lips, mixer paddles and other applications requiring high hardness in combination with high resistance to impact.

WELDING PROCEDURE:

Remove grease, oil and other contaminants prior to welding. With electrode vertical to work-piece maintain a short to medium arc-length. A weaving technique may be used where desired.

MECHANICAL PROPERTIES:

Hardness
58 - 60 HRC

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	80-90	100-110	130-150	170-180	190-230

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