

ARCTEC® 63 HARDCRO®



GENERAL CHARACTERISTICS:

ARCTEC® 63 HARDCRO® is a chromium carbide electrode producing a deposit suited for extremely abrasive operating conditions with moderate impact loads. It has excellent welding characteristics and produces deposits with a smooth surface. Machinable by grinding only.

APPLICATIONS:

ARCTEC® 63 HARDCRO® is suitable for hard surfacing components of earth moving equipment including conveyor screws, mixer paddles, pipeline elbows, tamper tools, sand chutes, bucket lips and teeth. Also suitable as final layer on rock crushing equipment and mill hammers.

WELDING PROCEDURE:

Clean the weld zone of all contaminants by grinding and remove previous deposits of hard-surfacing or apply a cushion layer with an ARCTEC® build up electrode before commencing with hard-surfacing. Stress relieving (cross-checking) may occur during cooling.

MECHANICAL PROPERTIES:

Hardness
58 RC - 63 RC

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	2.5mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	60-80	80-110	110-140	140-180	180-220

CALGARY FAX:(403)-250-7682 EDMONTON: (780)-484-4896 VANCOUVER: (604)-596-2940 WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355 (780)-484-3304 (604)-596-6207 (204)-663-9182

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