

ARCTEC® 63HS HARDCRO®



GENERAL CHARACTERISTICS:

ARCTEC® 63HS HARDCRO® is a heavily coated chromium carbide electrode for hardfacing of construction machinery and equipment components subject to high abrasion. This electrode has excellent welding properties and produces smooth bead surfaces. The high metal recovery (160%) and a high deposition rate makes this product very economical. Deposit is machinable by grinding only.

APPLICATIONS:

ARCTEC® 63HS HARDCRO® is suitable for economical hard overlays on shovel buckets and teeth, bulldozer corner bits, chutes, dragline chains, dredge pump impellers, fan blades, mill augers, hammer mill impeller, tamper tools, etc.

WELDING PROCEDURE:

Clean the weld zone free from oil, grease, rust, dirt and other contaminants. With electrode vertical to work piece, maintain a short arc. Application of a cushion layer is recommend for hard facing of manganese steels. Stress relieving (cross-checking) may occur during cooling.

MECHANICAL PROPERTIES:

Hardness
57-60 HRC

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	110-140	120-160	160-180	180-220

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