

# ARCTEC® 67 HARDCRO®



## GENERAL CHARACTERISTICS:

ARCTEC® 67 HARDCRO® is a chromium, vanadium, carbide composite electrode with a very high deposition rate. This electrode yields a deposit that is highly abrasion and crack resistant and retains high hardness at elevated service temperatures. Has excellent welding characteristics and easy slag removal. Machinable by grinding only.

## APPLICATIONS:

ARCTEC® 67 HARDCRO® is suitable as a hard overlay in applications subject to high abrasion at elevated service temperatures. Excellent for use in industries such as Cement Plants, Foundries and Steel Mills. Applications include kiln dampers, hammermills, slurry pipes, crusher hammers, scavenger fans and asphalt plant mixer paddles.

## WELDING PROCEDURE:

Clean the weld zone of oil, grease, rust and other contaminants by grinding if necessary. The weld deposit may be applied by using stringer or weave beads. Allow the weld deposit and surrounding area to cool slowly. Where deposits of more than three layers are required, intermediate cushion layers should be applied.

## MECHANICAL PROPERTIES:

Hardness	Temperature
67 RC	Ambient
50 RC	400°C / 752°F

## 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"
Amperage	170-190	210-230	250-270

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