

ARCTEC® 61 HARDCRO®



GENERAL CHARACTERISTICS:

ARCTEC 61® HARDCRO® is a hard facing electrode with a high deposition rate producing highly wear resistant deposits on structural and machine components subject to severe abrasion. It applies easily, without slag interference, and has equally good welding performance using either AC or DC equipment. Deposit is machinable by grinding only.

APPLICATIONS:

ARCTEC® 61 HARDCRO® is suitable for hard overlays on steel and alloyed steel. Ideal for hard surfacing components of earth moving equipment, augers, chutes, mill hammers, dragline buckets, bucket teeth, snow plow shoes, plow shears and on other equipment components subject to severe abrasion.

WELDING PROCEDURE:

Clean the weld zone free of all contaminants by grinding and remove previous deposits of hard-surfacing. With electrode vertical to work-piece maintain a short to medium arc-length. Weaving may be used. Application of a cushion layer is recommend for hard facing of manganese steels. Do not preheat manganese steel. Stress relieving (cross-checking) may occur during cooling.

MECHANICAL PROPERTIES:

Hardness
61 to 63 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	120-150	130-180	180-220	220-250

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