

TECHNICAL DATA SHEET

Starweld 490

AC / DC +

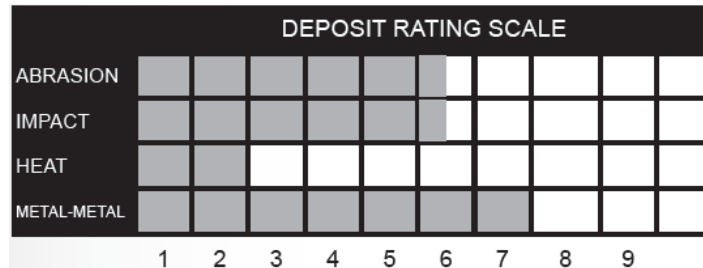
HARDFACING

Description :

All-position economical electrode for hardfacing on carbon steels, low alloy steels, cast steels and manganese steels subjected to abrasion, moderate impacts and metal-to-metal friction.

Characteristics :

- Excellent all-position weldability, even on AC power supply
- Crack-free deposit
- Smooth arc and low spatter
- Dense and porosity-free deposits
- Easy slag removal



Mechanical properties :

- Polarity AC / DC +
- Hardness (as-welded): 62 HRC
- 2 passes maximum are allowed

+ **Diameter**
+ **Amperage**

2.5 mm
75 A

3.2 mm
105 A

4.0 mm
150 A

5.0 mm
185 A

Applications :

Crusher jaws, plow blades, excavation equipments, pulleys, guides and transport rails, chisels, scrapers, bucket teeth, etc.

Also available in FCAW Starweld 3490 OA or Starweld 3490 FFG

1 800 361 9097

Starweld