

TECHNICAL DATA SHEET

 **Starweld 494**

AC / DC +

HARDFACING

Description :

High-recovery (160%) electrode with high chromium carbide for hardfacing mild steel, low alloy steel, stainless steel and manganese steel parts subjected to severe abrasion and moderate impacts.

Characteristics :

- Very high speed of deposit
- Smooth and dense deposit
- Very stable arc
- Very high deposit rate
- Taux de dépôt très élevé
- Minimum dilution rate for superior hardness, even at elevated temperatures
- Grindable deposits only

	DEPOSIT RATING SCALE									
ABRASION	1	2	3	4	5	6	7	8	9	10
IMPACT	1	2	3	4	5	6	7	8	9	10
HEAT	1	2	3	4	5	6	7	8	9	10
CORROSION	1	2	3	4	5	6	7	8	9	10

Mechanical properties :

- Polarity AC / DC +
 - Hardness (as-welded) : 60 HRC
- A maximum of two passes is allowed. If a cushion is required, use **Starweld 595**.

+ Diameter	2.5 mm	3.2 mm	4.0 mm	5.0 mm	6.3 mm
+ Amperage	90 A	120 A	170 A	235 A	280 A

Applications :

Bucket lips/teeth, conveyors, scrapers, crusher material, rollers, hammers, augers, press screws, excavation equipment, etc.

Also available in FCAW flux-cored wire Starweld 34940A

1 800 361 9097

 **Starweld**