

TECHNICAL DATA SHEET

Starweld 595

AC / DC +

REBUILDING

Description :

Electrode specifically designed for building up manganese steels (11-14% Mn), low carbon steels and low alloy steels subjected to severe impacts and moderate abrasion.

Characteristics :

- Ideal as a cushion before hardfacing with Starweld 494
- Machinable and work hardened deposits
- All-positions electrode with stable arc
- Multi-pass deposits
- Porosity-free deposit

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) : 250 BH
- Work-hardened : 550 BH

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

3.2 mm
115 A

4.0 mm
140 A

5.0 mm
185 A

Applications :

Brick and cement refractory press screws, mixer blades, ploughshares, bucket teeth, scrapers, ore crushers, etc.

**Also available in FCAW Starweld 25900A
and Starweld 2595 FFG**

1 800 361 9097

Starweld