

AC / DC +

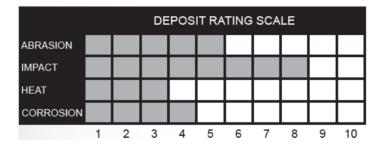
# REBUILDING

### **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



## **Mechanical properties:**

➤ Polarity AC / DC +

Hardness (as-welded): 250 BHWork-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

