

## TECHNICAL DATA SHEET

 **Starweld 595S**

**AC / DC +**

### REBUILDING

#### Description :

High-recovery electrode (140 %) for joining and build-up carbon steels, low alloy and 11-14% manganese steels (Hadfield steels). Ideal as a cushion before hardfacing. Excellent resistance to severe impacts with moderate abrasion and corrosion. Very interesting as a cushion before hardfacing when high thicknesses has to be deposited.

#### Characteristics :

- Exceptional resistance to impact and wear
- High resistance to abrasion and cavitation (high chromium content)
- Multi-pass depot with high recovery
- Excellent as a cushion before hardfacing with **Starweld 494**

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 +
- Tensile strength: 125 000 psi (865 MPa)
- Hardness (as-welded) : 200 – 250 BH
- Work-hardened : 400 – 500 BH

#### For manganese steels:

Weld with minimum energy input, low intensity, pulled passes, short cords, even immersing part of the part under water, to maintain an interpass temperature of 260°C. Do not pre-heat the part to be welded.

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

3.2 mm  
130 A

4.0 mm  
160 A

5.0 mm  
220 A

#### Applications :

Low alloy steel - manganese steel assemblies. Idlers, bottom and tread rolls, railroads crossings, switches and frogs, crusher rolls and cones, buckets teeth, etc.

**Also available in FCAW flux-cored wire Starweld 25950A**

**1 800 361 9097**

 **Starweld**