

ABRALOY 3505

Abraloy 3505 is a basic coated high recovery electrode which deposits a hard weld metal rich in chromium carbides. The chrome iron-type weld metal can provide antiwear deposit on carbon steels, low alloy steels as well as high manganese austenitic steels. The deposit has excellent abrasion resistance under low stress abrasion with mild medium stress grinding abrasion, impact loading conditions. Because of its high hardness it is recommended to be used as single layer hard facing also.

Applications:

This electrode is especially applicable for building corners and edges. Hence it is recommended for hardfacing of cane knives, Dozer end bits, Dozer blades, Crushing hammers, Rubber mixing blades, Dredger cutters, Dredger pump casings, Screws, Conveyers, Paddles and Wear pads.

Procedure:

- I Remove damaged, oxidized and fatigued metal.
- II Maintain short to medium arc.
- III Deposits consists of high percentage of chromium carbides uniformly and densely distributed in a hard matrix.

<u>Technical Data</u>	:	ABRALOY 3505		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	85 – 120	120 – 160	150 - 200
Hardness	:	60 - 64 HRC		
Tip Colour	:	Brown		

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