

## ABROCAR 184

Abrocar 184 is a specially formulated low heat input complex carbide Antiwear alloy electrode designed for very high abrasion resistant overlays on a variety of metal surface such as carbon steels, medium manganese steels, alloy steels, cast iron etc. The weld metal has a high hardness up to 65 RC even with very slow cooling rates. The complex carbides formed during welding give high resistance to high stress grinding abrasion, excellent resistance to galling and scratching abrasion.

### Applications:

Parts subjected to abrasion, impact and compressive loads like sand pumps, dredger pump parts, idlers, rollers, earthmoving and cement industry bucket lips, pug mill screws, power station coal nozzles and coal burners.

### Procedure:

Gouge out worn and fatigued base metal. Employ lowest possible current and weld with angle of 45-60° using skip and staggered weld technique. Use cushion layer of Tufaloy 320 or Hadmoloy 140 or Greloy 850 for multipass weld, depending on the base metal.

### Technical Data

Hardness on I layer	:	RC 60-62		
Hardness on II layer	:	RC 62-66		
Coating Color	:	Black		
Tip Color	:	White		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	90-130	100-160	140-200

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