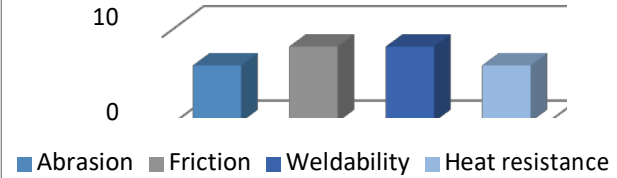


EXCEL HARD 008 PR



Alloy Characteristics



TYPICAL APPLICATION

Typical application includes pinch rolls, surfacing chipper knives, conveyor, bucket lips, shear blades and shovel dredgers and elevator bucket lips, rock crushers, rock drills, tractor grousers and paddlers.

PRODUCT FEATURES

1. Rapid rate of deposition with all position welding capability.
2. Flat, even flow and good weldability.
3. High resistance to abrasion and friction.
4. Very high recovery.

RECOMMENDATIONS

Hard facing electrode operates well in all condition positions. The deposited weld metal has exceptional abrasion and wear resistance in combination with resistance to heavy input. Evenly rippled, porosity free weld deposit permit heavy build-up without danger of cracking. Excel Hard 008PR is used as a base layer and Excel Hard 009PR as the final layer, which are especially designed for Pinch Rolls.

PROCEDURE

Ensure that the electrodes are perfectly dried before use. In case of moisture pickup, redry the electrodes at 200°C for one hour before use. Clean the weld area free of any surface contamination. Hold short arc length and weld with stringer beads.

RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
5.00	190 – 240
4.00	120 – 170

TECHNICAL DATA

1. Current: AC/DC +
2. Hardness: 42 – 48 HRC

Mfd. By EXCEL CRAFT PVT. LTD. (WELDING DIVISION)

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