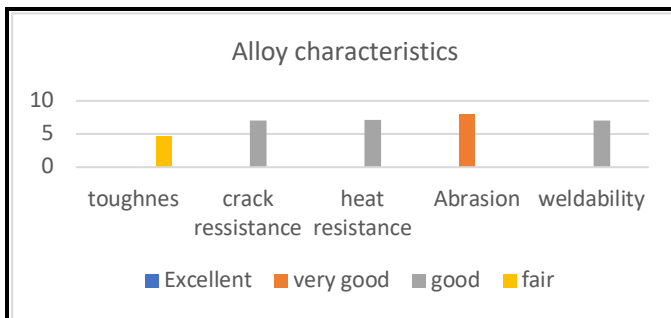


EXCEL HARD 010 AR



TYPICAL APPLICATION

Excel Hard 010 AR are used in heavy-duty industries for welding medium and heavy sections. Product is primarily used in applications where good wear resistance at elevated temperature is important along with considerable strength and toughness. Typical applications include chipper knives, conveyor bucket lips, shear blades, rock crusher, rock drills, hot work dies, crusher hammer. Specially designed for adamite roller's build up.

PRODUCT FEATURES

1. Highly appreciated for their strength, toughness, and crack resistance.
2. Operates well in all conventional positions.
3. Deposits is machinable with carbide tip tool.
4. No stress checks will be observed on machined surface.

RECOMMENDATIONS

Hard facing electrode operates well on all condition positions. The deposited weld metal has exceptional abrasion, heat, and wear resistance. Evenly rippled, porosity free weld deposit permit heavy buildup without danger of cracking. This is specially designed for adamite rollers.

PROCEDURE

Ensure that the electrode is perfectly dried before use. In case of moisture pick up, redry the electrodes at 200°C for one hour before use. Clean the weld area, remove fatigue material by machining and free it from all contaminations. Hold a short arc length with a short arc. Preheat the job if it contains C% higher than 0.4%.

RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
4.00	130-170
3.15	90-120

TECHNICAL DATA

1. Current: AC/DC +
2. Hardness: 50-55 HRC

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

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