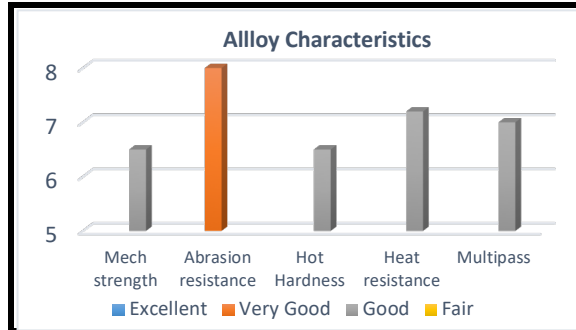


# EXCEL 347 S



## TYPICAL APPLICATION

Hard facing electrode with high metal recovery (180%) Exceptional abrasion resistance at temperature up to 650°C. For Hard facing of parts subject to heavy abrasion and metal wear with mild impact up to 510°C. Suitable for: refractory press screws, Brick press screws, Cement press screws, Palm nut press screws, Parts of crushers for friable materials, Conveyor screws, Impellers, edge runner bottom, plug mill, knife, boring bits, blast furnace bells and hoppers.

## PRODUCT FEATURES

1. Easy arc control in horizontal position.
2. High resistance to abrasive wear, impact, and compression.
3. High toughness & heat resistant up to 650°C
4. Flat, even flow, & easy slag removal.

## RECOMMENDATIONS

For Hard facing of parts subject to heavy abrasion and metal-to metal wear with mild impact up to 510°C.

## PROCEDURE

Use medium arc. To prevent excessive dilution with parent metal use low current. The recommended hardness is obtained only on the second or third layer.

## RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
5.00	180-240
4.00	130-170
3.15	90- 130

## TECHNICAL DATA

1. Current: AC/DC +
2. Hardness: 58 – 62HRC

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