



**Shri Balaji Alloys  
Corporation India**



# MAXIDURA - HF 103

FOR HOT ROLLED ROLLING MILL

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## ALLOY BASIS

Fe, Cr, Mn, C, V, W, Si

## PROPERTIES

Basic, all position electrode. The deposit is particularly resistant to heat and operates well in all conventional positions. Clean the surface thoroughly. Remove all cracked and spalled metal. Use short arc and lay stringer beads. Weld 2-3 layers. Finish weld metal by machining.

## TECHNICAL DATA

Hardness - 44 - 46 HRC

## TYPICAL APPLICATIONS

Include chipper knives, conveyor bucket lips, shear blades, rock crusher, rock drill, tractor grousers, hot work dies, crusher hammer, final layer on manganese steel parts subject to high abrasion or impact to protect it from initial wear.

## WELDING CURRENT

CURRENT	:	AC/DC(+)		
Size (mm)/Length	:	3.15×350	4.0×350	5.0×350
Current (amps)	:	70-110	90-140	130-180

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