



MAXIDURA - HF - 108

SPECIAL AUTHENTIC MANGANESE STEEL ELECTRODE.

ALLOY BASIS

Fe, Cr, Mn, C, Ni

PROPERTIES

The deposit is work-hardening type and highly resistant to cracking and deformation during working. Excellent abrasion resistance in the work hardened condition. Prolonged working life even when subjected simultaneously to impact and abrasion

TECHNICAL DATA

Hardness – 44 -46 **HRC**

TYPICAL APPLICATIONS

A Hard Facing Electrode operates well in all conventional positions. Typical applications include chipper knives, conveyer bucket lips, shear blades, rock crusher, rock drill tractor grousers, hot work dies, crusher hammer, and 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	3.15x350	4.0x350	5.0x350
Current(amps)	70-110	90-140	130-180

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