

## R-ALLOY 550

### An Air Hardening Type Electrode for Resistant to Severe Abrasion and Moderate Impact

**CHARACTERISTICS** : A medium heavy coated, air hardening electrode weld metal having typically hardness 550BHN. It is for overlaying hard surface on mild steel and low alloy carbon steel, deposits are non machinable and can only grounded. It is best suited for abrasion and impact or both together in service.

**APPLICATION** :

- 1) Mine rails, dredger bucket lips, plough shares.
- 2) Crusher hammers, drilling bits.
- 3) Bamboo and cane cutting knives, conveyor buckets, crane wheels, oil expeller etc.
- 4) Share blades, caterpillar treads, crane wheels etc.

**RE-DRY CONDITION** : Re-Dry the electrode at 110°C for 60 minutes, for best results.

**ALL WELD CHEMICAL COMPOSITION %**

C	Mn	Si	Cr	Mo	V
0.40-0.70 max.	0.60 Max	0.60 max	5.00-8.00	0.50-0.80	0.40-0.70

**WELD METAL HARDNESS**

Hardness
550 BHN Avg.

**DIEMENSION, CURRENT CONDITION & PACKING DATA**

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/ AC) Amps	Kg/pkt.	Kg/Case
3.15/ 3.20 X 450	1/ 8" X 18"	90-120	5	20
4.00 X 450	5/ 32" X 18"	145-175	5	20
5.00 X450	3/ 16" X 18"	180-210	5	20

Customer packing on request.