



PRODUCT DATA SHEET

HARDFACING ELECTRODES

WCD 6135

Tubecord D-2355



SUMMARY

- > High Chrome Carbide
- > Improved Abrasion Resistance
- > Welds can be Shaped by Grinding

IDENTIFICATION

Coating - Black **Tip** - Light Green

CLASSIFICATION

- > AS/NZS 2576: 2355-A1*
- * Nearest Classification

DESCRIPTION

Tubecord D-2355 deposits are high in carbon and chromium resulting in improved abrasion resistance. Tubecord D-2355 is ideal for hard surfacing components subjected to heavy abrasion and moderate impact loading.

No preheat is required for direct application onto grey cast iron, low carbon or manganese steels.

Deposits are grindable, subject to relief checking and may be multi-layered up to 3 layers. Features include, controlled fume levels, minimal spatter, easy bead deposition and low penetration.

Tubecord D-2355 is suitable for AC or DC applications.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE *(V)
6.3	450	85 - 135	25

*Voltage is determined by arc current and electrode arc length. Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Fe
5.5	0.4	38.4	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Single Layer Onto Mild Steel Typical Hardness 55 - 60 HRc

Single layer deposit hardness may vary depending on base metal type and degree of dilution.

APPLICATIONS

- > Dredge Bucket Lips
- > Shovel Buckets
- > Cone Crusher
- > Mill Hammers

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		PART NO.
	PACKET	CARTON	
6.3	5	15	TUBD60

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