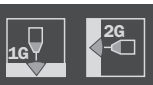
PRODUCT DATA SHEET

HARDFACING ELECTRODES

WCD 6121

Abrasocord 700



SUMMARY

- Wear Resistant, High Carbon Martensitic Steel Deposit
- For a Wide Range of General Hard Surfacing Applications, Such as Points, Tynes, Lips, Blades and Augers, ect.

IDENTIFICATION

Coating - Grey **Tip** - Orange **Imprint** - WIA AC 700

CLASSIFICATION

- AS/NZS 2576: 1855-A4

DESCRIPTION AND APPLICATION

Abrasocord 700 is a smooth running, AC/DC electrode which deposits an air hardening martensitic Cr-Mo-V steel alloy. Abrasocord 700 deposits one of the hardest steel alloys available and is free from relief checks. Abrasocord 700 deposits an air hardening steel alloy which can be readily hot forged and offers good resistance to all types of abrasion under low to moderate impact conditions.

In the “as welded” condition Abrasocord 700 weld metal cannot be machined without prior heat treatment.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
3.2	380	90 - 130	19
4.0	380	140 - 180	22
5.0	450	160 - 240	24

*Recommended for DC +/- or AC (minimum 45 OCV) operation.
**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	Si	Cr	Mo	V	Fe
0.7	0.3	0.5	8.5	0.3	0.5	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Singe Layer Onto Mild Steel	Typical Hardness 53 - 56 HRc
Multi-Layer	Typical Hardness 55 - 60 HRc

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

APPLICATIONS

- Post Hole Augers
- Agricultural Points
- Shears and Tynes
- Grader and Cultivator Blades
- Other Components Subject to Fatigue or Flexing During Service

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
3.2	5	15	29	HF70032
4.0	5	15	18	HF70040
5.0	5	15	10	HF70050

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