



# PRODUCT DATA SHEET

## HARDFACING ELECTRODES

WCD 6136

### Tubecord E-2460



#### SUMMARY

- > All Tubecord Electrodes are 450mm Long
- > Tubecord E-2460 is also Suitable for Vertical Up and Overhead Welding Positions
- > All Tubecore Electrodes are Coated with a Moisture Resistant, Non Alloying, Black Flux Coating, Resulting in Infinite Storage Life!

#### IDENTIFICATION

**Coating** - Black **Tip** - Blue

#### CLASSIFICATION

- > AS/NZS 2576: 2460-A1

#### DESCRIPTION

Tubecord E-2460 deposits contain carbon, chromium, niobium and molybdenum alloys for good resistance to both impact and abrasion:

Tubecord E-2460 produces a similar complex carbide iron deposit to the popular Abrasocord 43 electrode.

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

Deposits are grindable, subject to relief checking and should be restricted to 3 layers high.

Features include, controlled fume levels, minimal spatter, easy bead deposition and low penetration.

Tubecord E-2460 is suitable for AC or DC applications.

#### OPERATIONAL DATA

ELECTRODE SIZE (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE *(V)
6.3	90 - 130	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	Cr	Mo & Nb	Mn	Si	Fe
4.0	26.5	8.8	0.8	1.5	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Single Layer Onto Mild Steel      Typical Hardness 58-61 HRc

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

#### TYPICAL APPLICATIONS

- > Grizzly Bars
- > Bucket Teeth
- > Crusher Hammers
- > Rail Ballast Tampers
- > Dredger and Ripper Teeth

#### PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		PART NO.
	PACKET	CARTON	
6.3	5	15	TUBE60

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