

SMAW

For Hard Surfacing

HARDFACING ARC 33

CLASSIFICATION : JIS Z3251 DFCrA-700B

WELDING POSITIONS :



- **Hard, Wear Resistant Chromium Carbide Iron Deposit**
- **For Hard Surfacing Components Subject To Severe Abrasion And Heavy Impact**

DESCRIPTION AND APPLICATIONS

HARDFACING ARC 33 is a hard surfacing electrode that deposits very hard chromium carbides in an austenitic matrix. It is suitable for a wide range of surfacing applications where resistance to heavy abrasion and impact are required. The high chromium content (33%) make these electrodes deposits resistant to sea water corrosion and oxidation / spalling at elevated temperature up to 900°C. Typical applications are in the earth moving and mining industries and include surfacing quarry screen plates, screen butt straps, chutes and shovel teeth / lips.

DEPOSIT PROPERTIES

HARDFACING ARC 33 deposit are non-machinable, grindable, non-heat treatable and prone to relief checking. The high chromium carbide, iron deposit is ideal for all types of abrasion under high impact loading. For maximum wear resistance two layers may be required.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Cr	Fe
5.0	1.5	32.5	Bal

DEPOSIT HARDNESS

SINGLE-LAYER ONTO MILD STEEL•
MULTI-LAYER

TYPICAL HARDNESS 53 - 58 HRC
TYPICAL HARDNESS 60 - 65 HRC

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

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)	
			PKT	CTN
3.2	350	110 - 140	5	20
4.0	400	140 - 185	5	20

- Recommended for DC + or AC (minimum 70 OCV) operation

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