

SMAW **For Hard Surfacing** **HARDFACING ARC 43**

CLASSIFICATION : JIS Z3251 DFCrA-700B

WELDING POSITIONS : 

- Tough, Wear Resistant Complex Carbide Type Deposit
- For Hard Surfacing Components Subjected to Extreme Abrasion and Moderate to Heavy Impact

 DESCRIPTION AND APPLICATIONS

HARDFACING ARC 43 is a heavy coated, hard surfacing electrode depositing extremely hard, abrasion resistant Chromium/Niobium carbides in an austenitic matrix. It is ideal for hard surfacing applications where resistance to extreme abrasion (in particular sliding abrasion) and moderate to heavy impact are required. Due to the nodular shape of the complex carbides, HARDFACING ARC 43 deposits are capable of withstanding heavier impact levels than standard chromium carbide grades. Typical applications include bucket teeth/lips, grizzlies, press screws, crusher hammers and ripper teeth to name a few.

 DEPOSIT PROPERTIES

HARDFACING ARC 43 deposits are non-machinable, grindable, prone to fine relief checking and should be restricted to 3 layers high. While two layers of HARDFACING ARC 43 may be required for maximum wear resistance, this complex carbide alloy has lower dilution sensitivity than straight chromium carbide deposits.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)				
C	Mn	Cr	Nb	Fe
0.5	0.7	22.0	7.0	Bal

DEPOSIT HARDNESS	
SINGLE-LAYER ONTO MILD STEEL•	TYPICAL HARDNESS 60 - 65 HRC
MULTI-LAYER	TYPICAL HARDNESS 64 - 69 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	115 - 140	5	20
4.0	400	140 - 185	5	20

- Recommended for DC + or AC (minimum 55 OCV) operation

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