



# PRODUCT DATA SHEET

## HARDFACING ELECTRODES

WCD 6125

### ABRASOCORD 43



#### SUMMARY

- > Tough, Wear Resistant Complex Carbide Type Deposit
- > For Hard Surfacing Components Subjected to Extreme Abrasion and Moderate to Heavy Impact
- > Similar Deposit Type to Tubecord E-2460

#### IDENTIFICATION

**Coating** - Black **Tip** - Plain **Imprint** - WIA AC 43

#### CLASSIFICATION

- > AS/NZS 2576: 2465-A4

#### DESCRIPTION AND APPLICATION

Abrasocord 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, Abrasocord 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 but a few.

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

#### OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
3.2	380	115 - 140	19
4.0	380	140 - 185	22

\*Recommended electrical stick out is 15-20mm. Welding Current DC +

\*\*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Nb	Fe
5.0	0.7	22.0	7.0	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

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.

#### PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
3.2	5	15	16	AC4332
4.0	5	15	11	AC4340

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