

ISARC 61

Electrodes for reloading

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Classification: E 62 5 1,5NiMo B 42 (EN 757) E 10018-G (AWS A5.5)

Properties:

High-efficiency electrode (240%) thick-coated, depositing a heavily loaded alloy of chromium and Niobium carbides, very resistant to severe abrasion under medium shocks.

Soft and very pleasant fusion, dairy almost non-existent.

Applications:

Preventive recharging of any part subjected to strong abrasion by land, sand, minerals (mines and quarries), the glass industry, steel, cement plants, ceramics industry: extrusion screws, moulder screws, fan blades, mixer arms, bucket blades, propellers, dredging cutters, ore grinders, concrete pumps, steelworks agglomeration screens, drag chains, clods

Hardness

64 HRc

Packaging / Welding recommendations :

Ø x lg (mm)	3,2 x 350	4,0 x 450	5,0 x 450
Intensité	100 - 140	130 - 180	170 - 240
Kg / Etui	5	6	6
Pièces / Etui	75	46	29

- Continuous current (+ electrode) or alternative (Uo > 50 V)
- Heating process 1h à 130 °C (+/- 10°C) if necessary.
- Temperature of preheating between the passes accordingly to the metal fabricator.
- We recommend the application of an ISARC 307 sublayer before depositing on existing hard reloading.

Welding position:



Wear Resistance:









Equivalent to stuffed wire ISAFIL 61

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request