

# ISARC 65

**Electrodes for reloading** 

NEW TECH
Z.A. Le Pruney
315 rue Amable Matussière
38420 LE VERSOUD - FRANCE
(\*):+33458003488
info@newtech-revetements.com
www.newtech-revetements.com

Classification: E10-UM-66-GRZ (DIN 8555)

### Properties:

Thick, high-efficiency (240%) coating electrode, recommended for recharging parts that are subject to very high wear by abrasion, oxidation or erosion at high temperatures. The high composition of the complex carbide supply metal allows it to keep a high hardness up to  $600C^{\circ}$ . With controlled parameters, the deposit is almost free of slag.

#### Applications:

Reloading blast furnace bells, clinker shredders, sintering protectors and tools, clods, steel-conurbation fans, hot screens, molder screw heads for the ceramic industry, pieces of grinders and crushers working under low shocks and high pressures, manganese parts.

#### Hardness

64 HRc (45 HRc to 400 °C)

## Packaging / Welding recommadations:

Ø x lg (mm)	3,2 x 350	4,0 x 450	5,0 x 450
Intensité	120 - 140	140 - 180	180 - 230
Kg / Etui	5	6	6
Pièces / Etui	75	46	29

- Continuous current (+ electrode) or alternative (Uo > 50V).
- In case of application upon old hard reloads, we recommend applying un underlayer of electrode ISARC 307.
- Heating process: 1h to 130 °C in necessary.

# Welding position



#### Wear resistance









#### Equivalent to stuffed wire ISAFIL 65

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