

ISARC 67

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-65-GTRZ (DIN 8555)

Properties:

High-efficiency electrode (approximately 170%) depositing an alloy loaded with chromium and vanadium carbide offering extreme resistance to abrasion by fine particles as well as shocks, even at high temperatures. Its fine-grained structure prevents a possible loss of matrix by washing and ensures a high resistance of the metal deposited with scratch. Soft and very pleasant fusion, dairy almost non-existent.

Applications:

Endless screw reloading, brick crushers, grids, ore crushers, concrete and cement pumps, ventilator blades, screws and heads of moulders, blades and arms of mixers, glass and abrasive ore grinders, clods, dragging chains, dragheads and special foundation machinery,

Hardness

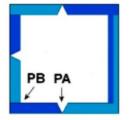
64 HRc (45 HRc à 400 °C)

Packaging / Welding recommandations:

| Ø x lg (mm) | 3,2 x 350 | 4,0 x 450 | 5,0 x 450 |
|---------------|-----------|-----------|-----------|
| Intensité | 110 - 140 | 140 - 180 | 180 - 230 |
| Kg / Etui | 6 | 6 | 6 |
| Pièces / Etui | 84 | 55 | 35 |

- Continuous current (+ electrode) or alternative (Uo > 50V).
- Choose the preheating temperatures and between the passes accordingly to the steel fabricator.
- In case of applications on old hard reloads, we recommend applying an underlayer at electrode ISARC307.
- Limit the application to 2 passes.
- Heating process: 1h at 130°C if necessary.

Welding position:



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