



ISARC 61

Electrodes for reloading

Classification : E 625 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

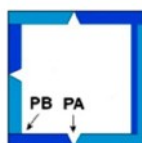
64 HRc

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:

ABRASION



CORROSION



IMPACT



TEMPERATURE



Equivalent to stuffed wire ISAFIL 61