



# ISARC 65

## Electrodes for reloading

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°. 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.

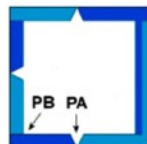
### Hardness

64 HRc (45 HRc to 400 °C)

### Packaging / Welding recommendations :

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 an underlayer of electrode ISARC 307.
- Heating process : 1h to 130 °C in necessary.



### Welding position

### Wear resistance



Equivalent to stuffed wire ISAFIL 65