



# ISARC 67

## Electrodes for reloading

**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,

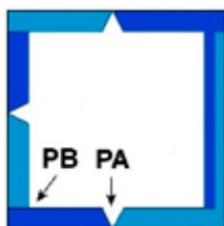
### Hardness

64 HRc (45 HRc à 400 °C)

### Packaging / Welding recommandations :

<b>Ø x lg (mm)</b>	3,2 x 350	4,0 x 450	5,0 x 450
<b>Intensité</b>	110 - 140	140 - 180	180 - 230
<b>Kg / Etui</b>	6	6	6
<b>Pièces / Etui</b>	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 :