

Hardfacing electrode resistant to Impact, compression and abrasion

STARBLAZE HF III

- ★ Hardness RC 57-61 Alloy for good abrasion resistance along with moderate impact resistance.
- ★ Excellent running performance.

Classification **DIN EN 8555: E6-UM-60P**

Description and applications Rutile type electrode for producing hard facing deposits for tough - hard, impact tough And abrasive resistant surfacing on unalloyed and low alloyed materials with higher tensile strength. Recommended for mixer blades, dipper teeth, metal cutting and forming tools, dies, drilling bits, punches, shears and croppers, crusher hammers, crane wheels, conveyor buckets etc..

Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	V	Mo	Fe
0.56	0.35	0.60	7.00	0.60	0.60	Rem

All weld metal Mechanical properties (Typical)

Hardness
57- 61 HRC

Obtained in pure weld metal

Amperes (A)

3.15mm	4.00mm	5.00mm
90- 120	140- 180	180- 240

Welding instruction

Guide electrode with a short arc. On materials sensitive to cracks use a buffer-layer of 18/8Mn type is recommended. Low alloyed, high carbon tool steels etc, have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

Welding Positions

 1G/PA	 2F/PB	 2G/PC	=+ (~50V)
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Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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