

DESIGNATION:
WELDING POSITION
Nouve Hard 550 R


Medium coated rutile type hard facing electrode depositing air hardening type specially designed for depositing alloy steel weld metal, which can resist severe abrasion and impact at elevated temperature.

FEATURES:

- Excellent arc characteristics
- Low moisture reabsorption
- Low spatter level
- Low smoke level
- Quick and easy slag removal
- Radiography quality

APPLICATIONS:

1. Electrode is highly suitable on wide variety of applications in steel plants such as blast furnace bells and hoppers, tong pins roll etc.

TYPE OF CURRENT:

- Direct Current Electrode Positive (DCEP)

RECOMMENDED WELDING TECHNIQUES:

GENERAL: Electrode positive, work negative (DCEP)

ARC LENGTH: Short arc

STORAGE: Re-dry electrodes to 250°C to 300°C for 1 hour before use.

ALLOYS:
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Carbon (C), Manganese (Mn), Chromium (Cr)

MECHANICAL PROPERTIES (As Welded):

MECHANICAL TESTS	TYPICAL
Hardness (above 3 rd layer)	51 HRC min

DIEMENSION, CURRENT CONDITION & PACKING DATA

DIAMETER (IN)	DIAMETER (MM)	PACKAGE	CURRENT CONDITION (DC+) Amps
1/8	3.15	5 Kg	80-110
5/32	4.0	5 Kg	90-130