

GRIDUR 555



IDENTIFICATION : GRIDUR 555

CHARACTERISTICS :

A medium-heavy-coated, basic type, hard facing electrode. The weld deposit is alloyed cast iron, which is hard, and extremely resistant to abrasion and metal-to-metal wear. The weld metal is so designed as to be especially resistant to scratching abrasion and to occasional grinding abrasion. The built-up surface does not deteriorate through furrowing, local plastic flow and micro cracking.

TYPICAL APPLICATION :

Oil expeller worms, concrete mixer blades, scrapper blades, screw conveyors, cement die rings Muller tyres, ploughshares, dippers, excavator teeth, etc.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr
2.10-2.90	0.80-1.20	2.2-3.60	0.03 max	0.03 max	2.90-4.0

HARDNESS OF WELD METAL :

On 3-layer Deposit: 575-600BHN

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+)	PACKING PER BOX (Pcs)	WEIGHT 1000 Pcs (KGS)
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3.15 / 3.20	450	90-120	120X4=480	36
4.00	450	110-150	80X4=320	58.50
5.00	450	150-200	55X4=220	90