

GRIDUR 600R



IDENTIFICATION : GRIDUR 600R

DESCRIPTION :

An extruded , rutile type heavy coated hard facing electrode with alloys in the coating.

APPLICABLE FOR :

Abrasion Proof hard facing of different parts made out of mild steel, structural steels manganese, hard steel and cast steel which are loaded by impact friction and rolling. Can be used on high carbon and high sulphur steels.

WELDING PROPERTIES :

Arc Striking and restriking properties are excellent. Very stable arc helps weldability in downhand, vertical -up and horizontal positions. Compact slag detaches easily. Weld metal is finely rippled . Deposit is air-hardenable and can only be ground.

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr
0.5-0.8	0.5-1.5	1.0 MAX	0.03 max	0.03 max	8.0-9.0

HARDNESS OF WELD METAL :

600-660 BHN = 55 - 56 HRC, depending on parent metal and welding conditions.

WELDING INSTRUCTIONS :

For applications on normal parent metals on special preparation is required. In case of high carbon steel buffer - layer with GEECON PURPLE is recommended. Redry electrodes at 7500 C for one hour for optimum results. For use on austenitic manganese steel a buffer layer of GRILOY - 7S is recommended.

TYPICAL USES :

Metal cutting and forming tools, punches, dies, drilling bits, shears, croppers, cane cutting Knives, bamboo chipper knives, oil expellers ,mine rails, crane wheels, mixer blades, dipper teeth, Steel mill parts, rollers , sliding surfaces, caterpillar tracks, excavator parts, rotors, crushing hammers, chunk jaws, shovel drive sprockets, mill hammers, impellers, large cog wheels, extruder screws, planner blades, drag buckets , rock drills, etc.

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS	PACKING PER BOX	WEIGHT 1000 Pcs (KGS)
2.50	350	80-100	120X4=480	44.63
3.15	450	100-130	65X4=260	60.00
4.00	450	130-160	55X4=220	93.74