

GRIDUR BELL



IDENTIFICATION : GRIDUR BELL

CHARACTERISTICS :

A heavy coated electrode for hardfacing applications where resistance to severe abrasion especially at elevated temperature is encountered. The weld deposit is alloyed with Cr-Ni-Mo to take care of additional impact in service. It retains hardness at relatively high temperature due to secondary hardening taking place. Weld metal does not crack during built-up operations by welding.

TYPICAL APPLICATION :

Ideal for applications where abrasive and corrosive conditions exist as in the blast furnace belts and hoppers, tong pins, hot shears etc.

Welding Currents: (Amps)	5.0 mm	4.00 mm	3.15 mm
	160-220	110-180	90-110

WELD METAL ANALYSIS (RANGE) % :

C	Mn	Si	S	P	Cr	Ni	Mo
0.4-0.55	1.2-1.8	0.20-0.60	0.03 max	0.03 max	1.6-3.50	4.4-5.8	4.8-5.5

HARDNESS (ON 3 LAYER DEPOSIT) :

1. At room temp. 50-55 RC
2. At 500°C 50-55 Rc or even more due to secondary hardening

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (-)	Wt PER 1000 Pcs, Kg (approx)	QUANTITY PER CARTON (Kg)	QUANTITY PER BOX
5.0	450	DC (+)	112	3	12
4.0	450	DC (+)	70	3	12
3.15	450	DC (+)	44	3	12