



PHILARK PH 14

Coated Electrode for For Hard-Facing, Wear-facing or Overlay Applications



General Description

PHILARK PH 14 is a hard surfacing electrode with excellent resistance to abrasion. The weld metal has a smooth burn off rate which produces evenly rippled beads. In addition to, exceptional abrasion and wear resistance the deposited metal is also suitable for heavy impact applications.

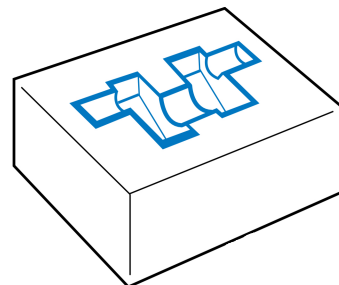
Mechanical Properties of Weld Metal

Hardness: 55-58 HRC

Typical Applications

- Fan Blades,
- Scrapers
- Road Rippers,
- Bucket Lips, Pads, Plow shears
- Chipper Knives
- auger, boring bits,
- Rock Drills and Rock Crushers
- Tractor Grousers and Paddlers.

Pressure									
Impact									
Abrasion									
Heat									



Forging Dies

Welding Parameters

Current Type and Polarity : AC/DC(+),
Welding Positions: Flat, Vertical.

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	90-130	140-175	170-210

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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