

PHILARK PH 68 NB

Coated Electrode for HARDFACING application at elevated temperatures



General Description

PHILARK PH 68 NB is a basic coated electrode that is highly resistant to abrasion wear caused by fine or coarse hard minerals in moderately high temperature environments about 800 degrees C. Produces an even droplet transfer in the spray arc form and features smooth welding bead.

It gives an austenitic weld metal with carbides such as Ti, Mo, V, WC, Nb, Co and Chromium. It's wear resistance is unmatched to Chromium Carbides at room temperatures owing to the presence of variety of Carbides formers giving an extra edge over others.

Pressure	1	2	3	4	5	6	7	8	9	10
Impact	1	2	3	4	5	6	7	8	9	10
Abrasion	1	2	3	4	5	6	7	8	9	10
Heat	1	2	3	4	5	6	7	8	9	10
Erosion	1	2	3	4	5	6	7	8	9	10

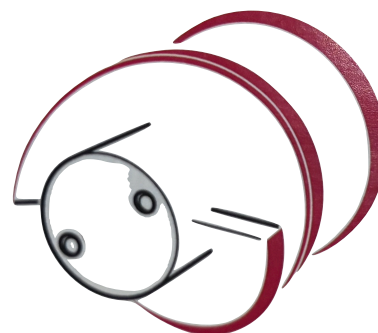
Mechanical Properties of Weld Metal

Hardness: 63-67 HRc (Single Layer)

Hardness on SS base: 58-60 HRc (Single Layer)

Typical Applications

- SS based Sector sets in Kiln Section
- Press Screws
- Extruder plates
- Clamping stops of Yokes
- Hammers and crushers
- Crusher jaws
- Guide plates
- Nozzle ring Liners
- Clinker pockets
- Chutes in high temperature zones
- Crushing mills
- Edge runners and chutes



Welding Parameters

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

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	110-140	150-180	160-190

PHILARK ALLOYS

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



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