



PHILARK PH 711

Coated Electrode for HARDFACING application



General Description

An AC/DC high chromium-carbide electrode. It has been designed to withstand high abrasive wear under pressure, combined with medium impacts which are specially caused by coarse sand and hard minerals. Also resistant to corrosion and oxidising. For overlaying carbon steels, low alloy steels and 12-14% austenitic manganese steels, it produces very thick deposits and so only one pass is usually required for most applications.

Deposits are smooth, of good shape and with little or no slag residues as the electrode is almost totally consumed in producing the weld bead. Deposits may check crack to relieve stresses but this will not adversely affect weld adhesion or wear characteristics.

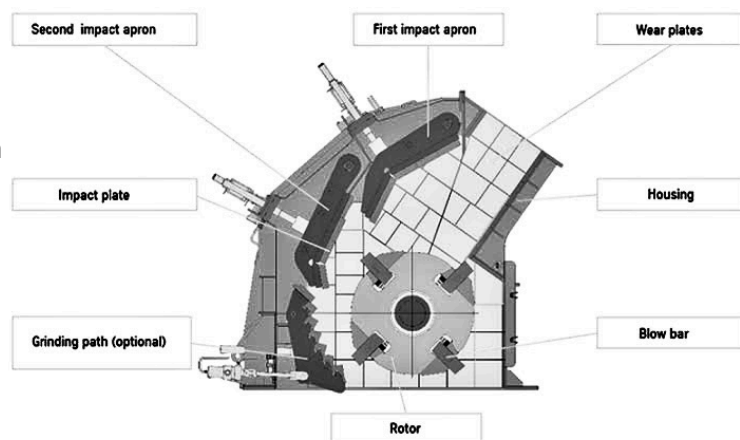
Pressure					
Impact					
Abrasion					
Heat					
Erosion					

Mechanical Properties of Weld Metal

Hardness: 60-63 HRc (Single Layer)

Typical Applications

- Dragline buckets (lips, points, cutting edges, teeth)
- Scraper blades and mixers
- Conveyor chains
- Mixer blades
- Sludge pumps
- Hammers and crushers
- Crusher jaws
- Guide plates
- Dozer and bits
- Clinker chains
- Screw conveyors
- Crushing mills
- Edge runners and chutes
- Moulding screen segments - Wearing strips
- Anchors



Wear parts of a Limestone Crusher

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	90-120	150-180	150-180

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