



PHILARK PH ABRAMAX

Coated Electrode for HARDFACING application



General Description

An AC/DC electrode which has high alloyed Cr-Mo-V weld metal. Deposits produce high resistance to pressure and abrasion and moderate impact resistance.

It is used on steels, alloy steels and carbon manganese steel components. The weld metal is heat resistant up to about 550°C. The alloy combines with a special flux coating formulation to provide a high metal transfer across the arc..

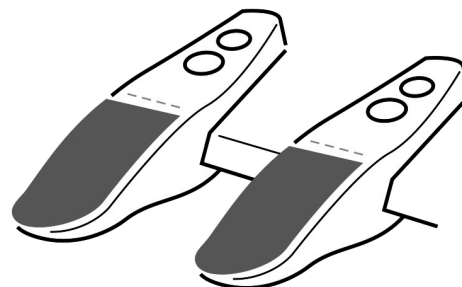
Mechanical Properties of Weld Metal

Hardness: 50-55 HRc (Single Layer)

Typical Applications

- Excavator buckets
- Dredge pump impellers
- Drill bits
- Crushers
- Breaker bars
- Gyratory crusher cones
- Bulldozer buckets
- Chipper rotors
- Screw conveyers
- Cold pressing tools
- Shear blades
- Slideways and guide rails

Pressure									
Impact									
Abrasion									
Heat									
Erosion									



Excavator Teeth

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	140-160	220-230	220-240

PHILARK ALLOYS

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