

AMERIARC

Ameri Hard 250H

INTERNATIONAL CLASSIFICATIONS

AWS – None
EN 14700 E Fe 1

DIN 8555: E1-UM-250

DESCRIPTION & APPLICATION:

Ameri Hard 250H is a machinable hard facing electrode designed for application where high build up depositing weld metal that results extreme compressive stresses.

The electrode is all positional & It has a metal recovery rate of 130%. Ideally suitable for depositing buffer layers and building up on mill rollers, rail, shafts etc.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	S	P	Cr	Ni	Mo	Fe
.08	1.85	.65	.012	.01	1.4	.72	.14	bal

Flux Color : Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Hardness:	Brinell 270

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+), or AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	140	180
Maximum Amperage	140	180	230

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	18" (450)	18" (450)	18" (450)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0