

AMERIARC

Ameri Hard 60H

INTERNATIONAL CLASSIFICATIONS	AWS/ASME NONE	DIN 8555: E6-UM-60-GP
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DESCRIPTION & APPLICATION:

Ameri hard 60H is a general purpose, retile coated hard facing electrode especially designed to use with small transformers having a relatively low open circuit voltage. It is resistant to softening up to 500°C.

It is used for hard facing of alloyed and unalloyed steels. Protective lining of worn surfaces of machines used in mines, bulldozer blades, excavator teeth, crushing laws, conveyors, agricultural and forestry machines that are exposed to wear can be hard face with this electrode.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	P	S	Cr	Ni	Mo	Fe
.56	.95	.43	.018	.014	5.7	.03	.63	Bal.

Flux Color : Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Hardness	Rockwell C56-58
Wear Co-efficient	2.8%

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+), AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	150	200
Maximum Amperage	130	190	260

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	14" (450)	14" (450)	14" (450)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0