

# AMERIARC

## Ameri Hard 66H

### INTERNATIONAL CLASSIFICATIONS

DIN 8555: E10-UM-65-G

### DESCRIPTION & APPLICATION:

**Ameri Hard 66H** is the high efficiency hardfacing electrode designed for application on abrasion resistance & moderate impact resistance. The electrode is also designed to produce cane spatter type deposition in the vertical welding position. Temperature required up to 500° C.

Application for conveyor screws mixer blades, pump & crusher hammers. And it also usage for sugar cane & cement industry.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

C	Mn	Si	Cr	Mo	Fe
4.3	0.4	0.7	10.2	1.9	Bal.

**Flux Color :** Grey

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Structure	Martensitic cast iron
Hardness	1 layer 59 HRc, 2 layers 61 HRc 3 layers 65 HRc, 4 layers 67 HRc
Wear Coefficient	2% (SiO <sub>2</sub> as abrasive)
Machinability	Grinding only

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Straight (-), AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	85	115	150
Maximum Amperage	120	150	190

### PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	14" (350)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0