

Basis Alloys :- C, Cr, Mo, Nb, W,V

CHARACTERISTICS : ECO 300D is an easily handled multi-carbide electrode formulated to deposit smooth weld beads at an especially high rate. The mix of primary and secondary carbides render deposits that are resistant to high pressure abrasion and particle erosion. It can be used on carbon steels, low alloy steels, manganese steel castings and AR plate .Electrode especially used for hard facing of parts subject to high abrasion,friction, heat and corrosion. Easy to weld, smooth drop transfer and negligible slag content. Metal recovery approx 200%.

APPLICATION : Welding suite for ash plows, coke crusher segments, screw conveyor, valves, agitator fingers, Mill guides ,Dragline Bucket parts,Mixer paddles, sludge pumps ,Manganese steel castings , AR plate Weld, Reinforcement etc.

TYPICAL WELDING PROCEDURE

Preparation: clean the weld area and remove scale and oxide. For parts below 40°F or over 1" thick, preheat to 150°F. Higher carbon steels require higher preheats (300°F-500°F). Do not preheat Hadfield manganese steel castings above 400°F .

Post-Welding: Slow cool parts in still air. High carbon steels and air hardenable steels should be covered with a heat retardant blanket.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hour,

TYPICAL WELD METAL HARDNESS :

As Welded hardness
62-68 HRC

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/ AC) Amps	weight of packet (Kgs)	Weight of Case
3.15/ 3.20	1/ 8"	100-130	2	10
4.00	5/ 32"	150-180	2	10
5.00	3/ 16"	190-240	2	10