

TM
CINOX 600

Unique alloy for abrasion and impact with soft running characteristics. Deposit not machinable. Earth moving, steel works and foundry equipment.

<i>Diameter</i>	<i>Amperage</i>
3.2mm/350mm	80 -120

CHARACTERISTICS AND TYPICAL APPLICATIONS

Basic coated high efficiency electrode with 130% recovery for hardfacing by applying rough-hard and abrasion-proof layers. Suitable for hardfacing on machine components made engineering steel, cast steel and manganese steel.

Smooth, intense fusion, fine-scaled seam, and easy slag removal. The pure weld deposit is only machinable by grinding. The electrode has a soft but intensive welding character, a fine-structured seam surface and excellent slag-removal properties. Suitable for hardfacing on machine components made of engineering steel, cast steel and manganese steel.

APPLICATION

Ideal for repairing and rebuilding shear blades, percussion drills, earth borers, crusher jaws, rollers, rolling crushers etc.

WELDING TECHNIQUES

Do not pre-heat. Use string or weave bead technique to deposit material. Avoid overheating on any manganese steel base metals.

TYPICAL MECHANICAL PROPERTIES

<i>Undiluted Weld Metal Hardness</i>	Maximum Value up to: Rockwell 55-60
<i>Recommended Current</i>	- DC reverse polarity (Electrode +) or AC
<i>Welding positions</i>	- Flat, Horizontal, Vertical up, Overhead