

BOR-A(R)

CODIFICATION: IS : 7303 E Fe-A312(Nearest)

CHARACTERISTICS AND APPLICATIONS:

BOR-A (R) is a hardfacing electrode operating on AC / DC(-) depositing an air hardening weld metal . The deposit displays excellent toughness and ability to withstand heavy impact loads and has excellent resistance to rolling and sliding friction. The weld deposit is machinable. Ideal for rail points and crossings, axles, wheels, gear shafts, couplings, pinion teeth, rollers, sprockets, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 0.20	0.60	0.40	1.80

WELD METAL HARDNESS : 250-280 BHN

CURRENT AND PACKING DATA : AC / DC(-)

Size (mm)	: 5x450	4x450	3.15x450	2.5x350
Dia x Length				
Current Range	: 190-220	140-180	100-130	65-90
(Amps)				
Qty.(Pcs./Carton)	: 50	80	120	180

PRECAUTIONS:

1. Use short arc.
2. Use low current.
3. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 150°C for one hour.
4. If the base material has the carbon content of more than 0.25% a buffer layer using a low hydrogen electrode is recommended.