



CROMA

CHARACTERISTICS AND APPLICATIONS :

Croma is a AC/DC (+) type electrode depositing a 16Cr-4Mn weld metal which has work hardening characteristics. The weld metal resists impact abrasion and corrosion. Ideally suited for hardfacing applications to enhance resistance to impact abrasion. Ideal for buffer layers before depositing air hardening deposits. Typical applications include surfacing and building up of austenitic manganese steel components, crusher jaws, crusher hammers, roll crushers, mining machineries, dipperteeth, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 0.12	4.30	0.55	16.5

WELD METAL HARDNESS: As welded: 200-250 BHN

Work hardens (under impact) to 550 BHN

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	: 180-250	150-180	100-140	70-90
(Amps)				
Qty.(Pcs./Carton)	: 25	40	65	100

PRECAUTIONS:

1. Ensure the electrodes are dry. Moist electrodes should be redry at 200-250°C for one hour.
2. Use minimum current and as low heat input as possible.