



## SHC-SIX

### CHARACTERISTICS AND APPLICATIONS :

SHC-Six is an unique electrode operating on AC / DC (+) depositing an air hardening weld metal which has excellent resistance to severe abrasion with moderate impact as in the case of oil expeller worms, dipper teeth, scraper blades, screw conveyers, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 3.0	1.50	1.50	5.0

**WELD METAL HARDNESS:** 54-60 RC

### CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x450	4x450	3.15x350
Dia x Length			
Current Range	: 170-200	140-170	110-130
(Amps)			
Qty.(Pcs./Carton)	: 40	60	80

### PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 200-250°C for one hour.
2. Use short arc and stringer beads.
3. Use suitable buffer layers and preheat depending on base material composition and thickness.