

## THERMEHARD 55

### CHARACTERISTICS AND APPLICATIONS :

A special type hardfacing electrode depositing Ni-Mo alloy. The weld metal possesses high hardness which is retained even at elevated temperature of 550°C. Ideal for hardfacing components which are subjected to abrasion in combination with impact like blast furnace, belt, hoppers, rolls, tong pins, etc.

### WELD METAL HARDNESS :

At room temperature : 50-55 RC  
 At 500°C : 45 RC

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

Size (mm)	:	6.3x450	5x450	4x450	3.15x450
Dia x Length					
Current Range (Amps)	:	200-250	160-190	130-160	100-130
Weight/Carton (kgs)	:	4	4	4	4

### PRECAUTIONS:

1. The electrode should be redry at 250°C for one hour before use.
2. Clean the weld area thoroughly from rust, scale, paint, oil, grease or any other contaminants.
3. Use short arc.