

GOLD 330-E FOR HIGH ALLOY AND DISSIMILAR STEELS

Description and Applications:

Multipurpose high strength ferrite-austenitic electrode for repair welding on alloy and high-alloy-steels, tool-steels, stainless steels and dissimilar assemblies.

The **high mechanical properties** combined with an **excellent welding performance** make this electrode ideal for repair of Shovel buckets, chassis, springs, plates, drill bits, moulds, dies, press tools, chains, crane booms, shafts, tools, armour plates, rotors....

This electrode should not be missed in any repair shop.



Repair broken gears



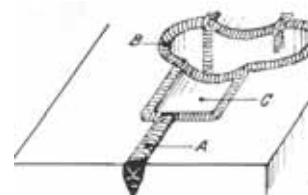
Rebuild worn shafts



Weld dissimilar steels



Repair cracks in chassis



Repair tools and dies

Mechanical properties
Up to :

R_m (MPa)	R_{p 0,2} (MPa)	A₅ (%)
800	550	25

Packaging
Data

Sizes	2.0x300	2.5x300	3.2x350	4.0x350
Kgs/Packets	3,5	4	4,5	4,5
Packets/carton	4	4	4	4
Kgs/carton	14	16	18	18

Welding instructions

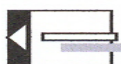
Current (A)	50	80	110	140
--------------------	----	----	-----	-----



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE



= + ~50V

FEATURES

Highest crack resistance. Able to weld over 1000 different steels and steels of unknown analysis.

Low amperage coating reducing heat input, preventing cracking and distortion.

Ideal For use as buffer layer prior to hard facing (Hardness 240-280 HV 30)

Welds successfully even on rusty contaminated surfaces. weld deposit can be machined and will work harden in service. Can be used on AC or DC Machines with excellent weld ability.