

GOLD 710-E

FOR REBUILDING & SURFACING

Description and Applications:

Electrode with a semi-hard and machinable deposit.

For use in the following industries: cement, chemical, engineering, mining, steelworks etc.

Applications: rebuilding and surfacing of rails, drive sprockets, gear teeth, drag line chains, wobblers, wheels etc.

Also applied as a cushion layer prior to hard facing with gold 730, 750 or 760.

Weld deposit will resist severe impact and deformation.

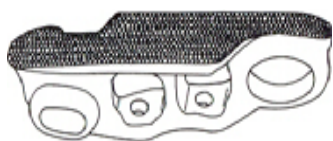
Fast deposition in all positions.

Good machinability. Deposit can be flame cut

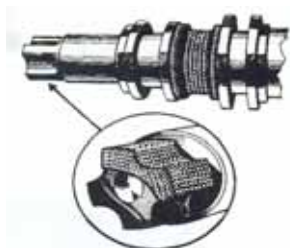
Weld metal contains: Fe, Cr, Mn, Si, C



Rebuild wheels



Rebuild tractor pads



Repair wobblers/and couplings



repair drive sprocket/gears



Mechanical characteristics :

Hardness	~ 350 HB		
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Packaging Data

Sizes	3.2x350	4.0x450	5.0X450
Kgs/packet	4,5	5,5	5,5
Packets/carton	4	4	4
Kgs/carton	18	22	22

Welding instructions	Current (A)	110	140	170
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1G/PA



2F/PB



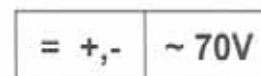
2G/PC



3G/PF



4G/PE



Clean area to be over laid. When surfacing iron based metals undercut (machine) area by 4-6mm undersize Remove old welds by using gold 110 gouging electrode.
Preheat according to base metal. Select recommended amperage and use DC reverse polarity.
Deposit electrode with stringer beads and use short arc, avoid excessive weaving.
Ensure that each weld overlaps the previous weld. Remove slag from each weld bead before applying next bead.