

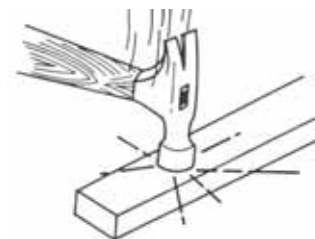
GOLD 730-E

ANTI- WEAR ELECTRODE

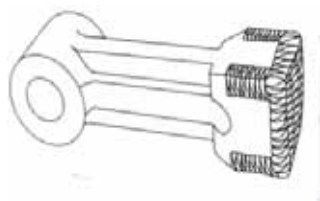
Description and Applications:

All position general purpose hard facing electrode for overlays which **resist high impact and pressure**. The deposit is tough hard and can also be used with one or two layers of **Gold 750** on top. **Typical applications are bucket edges, crusher rollers, mill hammers, cams, bulldozer blades, cutting edges, grab jaws, ripper teeth and chisels.**

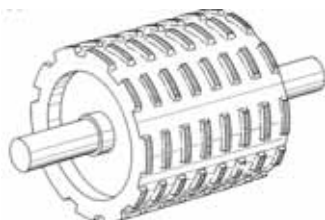
- Multi pass build up possible without cracks.
- Heat treatable deposit
- All position weldability
- Easy striking almost spatter free welding
- for use on steel, manganese steel, and malleable iron



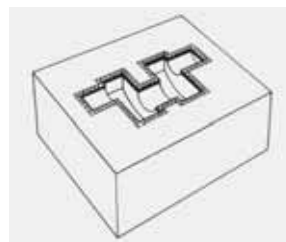
For high impact and medium abrasion resistance



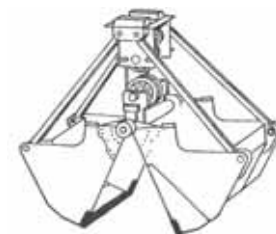
Protect and rebuild crusher/ swing hammers



Crusher roller



Overlay press tools



Earth moving buckets
Edge protection

Mechanical properties

Hardness	~	60 HRC
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Packaging data

Sizes	2.5x350	3.2x350	4.0x450
Kgs/ Packet	4,5	4,5	5,5
Packets/ carton	4	4	4
Kgs/ carton	18	18	22

Welding instructions

Current (A)	80	110	150
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Clean area to be hard faced . Remove old hard facing and fatigue metal by gouging with gold 110 and grinding

Preheat according to base metal. Select recommended amperage and use DC reverse polarity. Deposit electrode with stringer or weaving 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.

Deposit a minimum of two layer for best results. Avoid excessive heat build up. Allow to cool slowly. Deposit can be annealed (2 hours at 850°C) followed by slow cooling