

GOLD 740-E

FOR HEAVY IMPACT AND PRESSURE

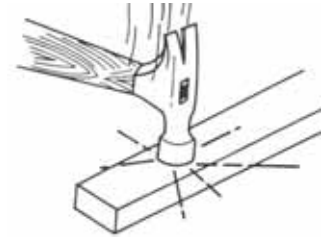
Description and Applications:

Manganese alloy electrode for overlays which are subjected to extreme impact. The overlay has a strong work hardening tendency, is highly crack resistant and **the thickness is not limited**.

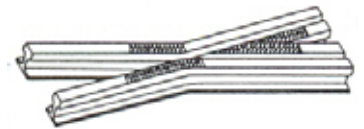
One or two final layers with **Gold 750** increase the abrasion resistance.

Applied in mining, cement industries, rail rods, quarries, steel mills, for **milling hammers, crusher jaws, guides and rails, switches, tongues and crossings, buckets**

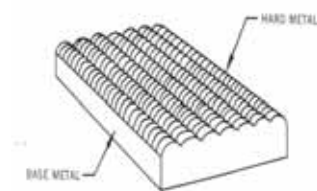
Excellent as cushion and build up electrode before hard facing with 750, 760 or 770. Hardness of weld deposit increases during service.



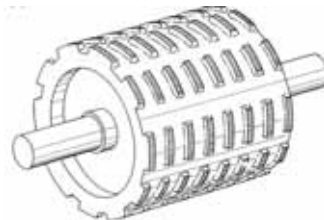
For high impact resistance



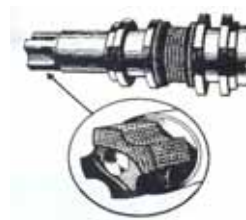
rails (frogs and crossovers)



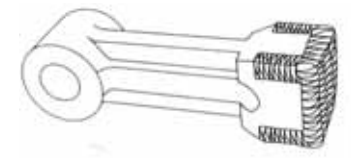
Protect and rebuild crusher Jaws



Crusher roller



Wobblers/couplings



Crusher hammers

Mechanical properties

Hardness as welded : ~ 250HB	After work hardening : ~480HB
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Packaging Data

Sizes	3.2x450	4.0x450	5.0x450
Kgs/Package	5,5	5,5	5,5
Packages/carton	4	4	4
Kgs/carton	22	22	22

Welding instructions	Current (A)	130	160	200
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= +,- ~ 70V

Clean area to be overlaid. Remove old hard facing and fatigue metal by gouging with gold 110 and grinding. Preheat according to base metal. Do not preheat manganese steel and check that inter pass temperature do not exceed 150 C during welding. If possible place part in a water bath during welding. 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.