

GOLD 750-E

FOR HIGH MINERAL ABRASION

Description and Applications:

Stick electrode For hard facing of parts subject to mineral abrasion.

For anti rear protection in cement works, earthmoving, quarries, steelworks, foundries, and sugar industries.

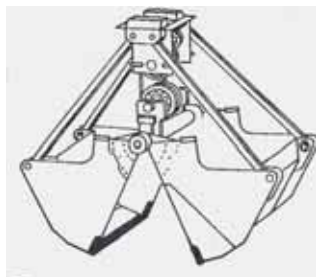
Use to protect buckets, **bulldozer blades**, **crusher rollers**, **impellers**, **screw conveyors**, **Mixer blades**, **fans etc**

Can be applied on carbon and alloy steels, manganese and cast iron.

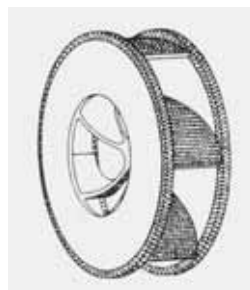
- Excellent for abrasion accompanied by low to medium impact
- high compressive strength and good weldability
- smooth deposits, high corrosion and heat resistance
- **Weld deposit: High Chrome carbide**



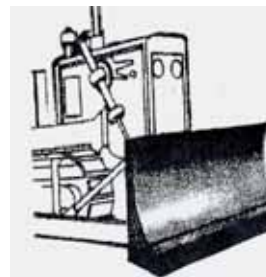
Protect screws for cement, sand, stone



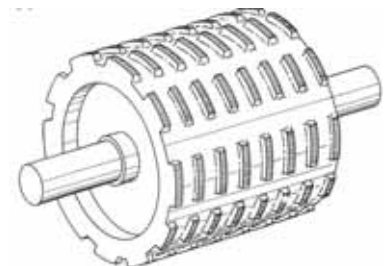
Protect Buckets



Fans /rotors



Bulldozer blades



Crusher rollers

Mechanical properties

Hardness : **58** - **63** **HRC**

Packaging Data

Sizes	3.2x450	4.0x450	5.0x450
Kgs/ Packet	5	5	5
Packets/carton	4	4	4
Kgs/ carton	20	20	20

Welding instructions	Current (A)	135	160	210
----------------------	-------------	-----	-----	-----

= + ~ 50V

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. Select recommended amperage..

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 two layer for best results. (maximum 3 layers is recommended) Allow to cool slowly.

Small cracks can appear when using applying 3 layers due to formation of chromium carbides.

Such cracks are normal and do not affect the part or the lifetime of the part.