

GOLD 760-E

FOR EXTREME MINERAL ABRASION

Description and Applications:

Stick electrode for hard facing of parts subject to extreme mineral abrasion and heat. For cement, earthmoving, quarries, steelworks, foundries, and sugar industries.

Use to protect buckets, **bulldozer blades, crusher rollers, impellers, screw conveyors, mixer blades, dredger teeth, fans etc.**

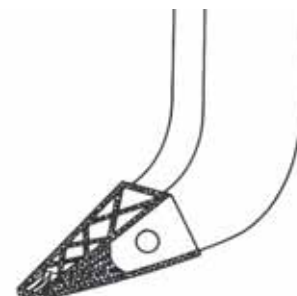
Can be applied on carbon and alloy steels, manganese and cast iron.

-Excellent for abrasion accompanied by low impact

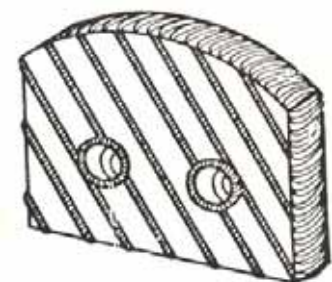
-high compress strength and good weldability

,-high recovery electrode(200%), high corrosion and heat resistance

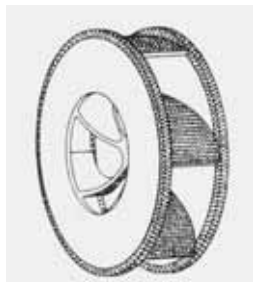
WELD DEPOSIT: CHROME, NIOBIUM, MOLYBDENUM(Fe)



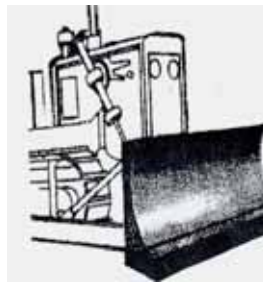
Ripper teeth protection



Protect mixer blades/paddles



Hard face Fans /rotors



Bulldozer blades



Conveyor screws

Mechanical properties

Hardness :

~ 64 HRC

Packaging Data

Sizes	3.2x350	4.0x450	5.0x450
Kgs/Packet	4	5	5
Packets/carton	4	4	4
Kgs/carton	16	20	20

Welding instructions

Current (A)	140	180	230
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Clean area to be over laid . 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 and use DC reverse polarity.

Deposit electrode with stringer or weaving beads and use short arc, avoid excessive weaving.

One or 2 pass (layer) is normally applied. if higher build up is needed use 320 or 710 as buffer layer. If hardfacing on cast iron use gold 420 as buffer layer.

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

Such cracks are normal and do not affect the part or the wear life of the part

