

GOLD 780-E FOR EXTREME MINERAL ABRASION

Description and Applications:

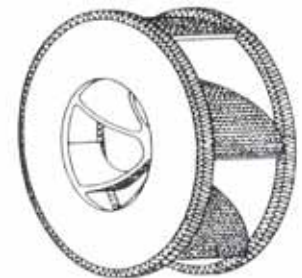
Tubular electrode filled with **tungsten carbides**, for application subject to extreme scraping abrasion.

Used for maximum protection against mineral abrasion on the following parts.

Fan and mixer blades, screw conveyors for ash cement ,sand and pulp, dry cement pumps, rotary drills, brick dies and presses, shredder knives, rip-per teeth, debarker tools (wood), stabilizers, elbows of concrete pumps

This alloy is also available as a gas welding rod (780 G)

Single pass deposit provides highest abrasion and erosion resistance.



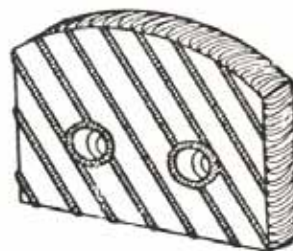
Rotor/fan blades



Augers/ screws



Stabilizer



Protect mixer blades



Debarking tools/knives

Mechanical characteristics :	Hardness ~ 68 HRC Tungsten carbides 2000HV	
Packaging Data	Sizes	4.0x350
	Kgs/Package	5
	Packages/carton	4
	Kgs/carton	20
Welding instructions	Current (A)	110



= + ~ 50V

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. Select recommended amperage and use DC reverse polarity.

Deposit electrode with stringer beads .excessive weaving is not recommended as it will degrade the wear properties of the weld metal. On hard steels apply buffer layer of 330 or 510. on cast iron use buffer layer of gold 420 .

Generally one layer of gold 780 will give sufficient protection.