



ABRASOCORD 43

- ▶ Tough, Wear Resistant Complex Carbide Type Deposit
- ▶ For Hard Surfacing Components Subjected to Extreme Abrasion and Moderate to Heavy Impact
- ▶ Similar Deposit Type to Hardcore 2460 and Tubecord E-2460

Identification

Coating - Black **End Tip** - Plain

Classifications

AS/NZS 2576 2465-A4
WTIA Tech Note 4 2465-A4

Description & Applications

ABRASOCORD 43 is a heavy coated, hard surfacing electrode depositing extremely hard, abrasion resistant Chromium/Niobium carbides in an austenitic matrix. It is ideal for hard surfacing applications where resistance to extreme abrasion (in particular sliding abrasion) and moderate to heavy impact are required. Due to the nodular shape of the complex carbides, Abrasocord 43 deposits are capable of withstanding heavier impact levels than standard chromium carbide grades. Typical applications include bucket teeth/lips, grizzlies, press screws, crusher hammers and ripper teeth to name but a few.

Abrasocord 43 deposits are non-machineable, grindable, prone to fine relief checking and should be restricted to 3 layers high. While two layers of Abrasocord 43 may be required for maximum wear resistance, this complex carbide alloy has lower dilution sensitivity than straight chromium carbide deposits.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
3.2	380	115 - 140	19
4.0	380	140 - 185	22
5.0	450	190 - 255	24

*Recommended for DC+ or AC (minimum 55 0CV) operation

** Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

Issue AB

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The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

Typical All Weld Metal Chemical Analysis

C	Mn	Cr	Nb	Fe
5.0	0.7	22.0	7.0	Bal

Typical All Weld Metal Mechanical Properties

Single Layer onto Mild Steel	Typical Hardness 60-65 HRC
Multi-Layer	Typical Hardness 64-69 HRC

Single layer deposit hardness may vary depending on base metal type and degree of dilution.

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton		
3.2	5	15	16	AC4332
4.0	5	15	11	AC4340
5.0	5	15	6	AC4350

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.