



ABRASOCORD 700



- ▶ Wear Resistant, High Carbon Martensitic Steel Deposit
- ▶ For a Wide Range of General Hard Surfacing Applications, such as Points, Tynes, Lips, Blades and Augers, etc

Identification

Coating - Grey

End Tip - Orange

Classifications

AS/NZS 2576 1855-A4

WTIA Tech Note 4 1855-A4

Description & Applications

ABRASOCORD 700 is a smooth running, AC/DC electrode which deposits an air hardening martensitic Cr-Mo-V steel alloy. Abrasocord 700 deposits one of the hardest steel alloys available and is free from relief checks. Applications include the surfacing of post hole augers, agricultural points, shares and tynes, grader and cultivator blades and other components subject to fatigue or flexing during service.

Abrasocord 700 deposits an air hardening steel alloy which can be readily hot forged and offers good resistance to all types of abrasion under low to moderate impact conditions. In the "as welded" condition Abrasocord 700 weld metal cannot be machined without prior heat treatment.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
3.2	380	90 - 130	19
4.0	380	140 - 180	22
5.0	450	160 - 240	24

*Recommended for DC+ or AC (minimum 45 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.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	Cr	Mo	V	Fe
0.7	0.3	0.5	8.5	0.3	0.5	Bal

Typical All Weld Metal Mechanical Properties

Single Layer onto Mild Steel	Typical Hardness 53-56 HRC
Multi-Layer	Typical Hardness 55-60 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	Mini Pak		
3.2	5	15	0.5	27	HF70032 HF70032M
4.0	5	15	-	18	HF70040
5.0	5	15	-	10	HF70050

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.