PRODUCT DATA SHEET

WCD 6135

HARD FACING ARC WELDING ELECTRODES

TUBECORD D - 2355

- High Chrome Carbide
- Improved Abrasion Resistance
- Welds can be Shaped by Grinding

Identification

Coating - Black

End Tip - Light Green

Classifications

AS/NZS 2576 2355-A1*

*Nearest Classification

Description & Applications

Tubecord D - 2355 deposits are high in carbon and chromium resulting in improved abrasion resistance. Tubecord D - 2355 is ideal for hard surfacing components subjected to heavy abrasion and moderate impact loading. No preheat is required for direct application onto grey cast iron, low carbon or manganese steels.

Applications include the hard surfacing of dredge bucket lips, shovel buckets, scraper and dozer sides, cone crushers and mill hammers, etc. Deposits are grindable, subject to relief checking and may be multi-layered up to 3 layers. Features include, controlled fume levels, minimal spatter, easy bead deposition and low penetration.

Tubecord D - 2355 is suitable for AC or DC applications.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	ARC VOLTAGE RANGE (volts)**
6.3	450	85 - 135	25
8.0	450	130 - 190	29

*Recommended for DC+ /- or AC (minimum 70 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	Cr
5.5	1.5	40.0

Typical All Weld Metal Mechanical Properties

Single Layer	Typical Hardness 55-60 HRc*

*Nearest Classification

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		PART NUMBER
	Packet	Carton	
6.3	5	15	TUBD60

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The intergrity 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.

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