



COMPLEX CARBIDE TUBECORD E 2460



- ▶ All Tubecord Electrodes are 450mm long.
- ▶ 6.3mm Tubecord E - 2460 is also suitable for vertical up and overhead welding positions.
- ▶ All Tubecore Electrodes are coated with a moisture resistant, non alloying, black flux coating, resulting in infinite storage life!

Identification

Flux Coating - Black

End Tip - Blue

Classifications

AS/NZS 2576	2460-A1
WIA TECH NOTE	2460-A1

Description & Applications

TUBECORD E - 2460 deposits contain carbon, chromium, niobium and molybdenum alloys for good resistance to both impact and abrasion:

Deposit hardness (single layer): 58 - 61 HRc

Tubecord E - 2460 produces a similar complex carbide iron deposit to the popular Abrasocord 43 electrode.

No preheat is required for direct application onto grey cast iron, low carbon or manganese steels.

Applications include the hard surfacing of grizzly bars, bucket teeth, crusher hammers, rail ballast tampers, dredger and ripper teeth, etc.

Deposits are grindable, subject to relief checking and should be restricted to 3 layers high.

Features include, controlled fume levels, minimal spatter, easy bead deposition and low penetration.

Tubecord E - 2460 is suitable for AC or DC applications.

Operational Data

ELECTRODE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
6.3	90 - 130	25
8.0	135 - 185	29

* 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	Cr	Mo	Nb	V	Mn	Si
4.0	26.5	0.9	7.9	0.4	0.8	1.5

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		PART NUMBER
	Packet	Carton	
6.3	5	15	TUBE60
8.0	5	15	TUBE80

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.