



# Hard Facing Electrodes

## ALPHA HARD - I

### Characteristics:

**ALPHA HARD - I** is a medium heavy coated, rutile type, hard facing electrode. Weld deposit is air hardening type and can withstand heavy impact load. It gives machinable weld deposit of approx. 250 BHN hardness. To be used with buffer layer of Alpha-7016 on hard base material. Recommended for hard facing on Mild Steel, Carbon steel & Low Alloy Steels.

### Applications:

The weld metal is hard, tough and easily machinable. It is used for Repair and Filling up worn out machine parts, Gear Teeth, Shaft Couplings, Mill Guide Plates, Pulleys, Axles, clutches, Sugar Cane Crushers, Rail Ends and Crossing etc.

### Typical Weld metal Composition

Element	Percent
C	0.20-0.30
Mn	0.25-0.60
Si	0.15-0.25
Cr	0.50-1.00

**Hardness: 240-280 BHN on 3rd layer deposit.**

### Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC or DC (-)	Pieces per Packet	Pieces per Carton
5.00x450	170-210	65	260
4.00x450	130-160	95	380
3.15x450	90-110	150	600

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