



Hard Facing Electrodes

ALPHA HARD - V

Characteristics:

ALPHA HARD - V is a medium heavy coated, rutile base, air hardening type hard facing electrode. Gives weld deposit of 500 BHN. Weld is non-machinable but can be ground. It is resistant to severe abrasion & moderate impact. Two or three layer deposits are recommended as the first layer may not develop the full hardness due to dilution. Recommended for Mild Steel, structural steel & cast steels.

Applications:-

Reinforcing worn rails, Crane wheels, Worn-out parts of Earth moving equipments, Bamboo chipper knives, Sprockets, Shears & Croppers, Muller types, Ploughshares, Drill bits, Mine rails, Oil expellers, Caterpillar threads etc.

Typical Weld metal Composition

| Element | Percent |
|---------|------------|
| C | 2.0 - 2.50 |
| Mn | 0.50-1.50 |
| Si | 0.50-1.50 |
| Cr | 3.0-4.0 |

Hardness: 480-530 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 | 160-200 | 65 | 260 |
| 4.00x450 | 120-160 | 80 | 320 |
| 3.15x450 | 90-120 | 150 | 600 |

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