

## **DUROID 650B**

### **No-problem abrasion resistance even for thicker plates**

A high alloyed basic hardfacing electrode depositing a nonmachinable air-hardening weld metal. The weld deposit is resistant to severe abrasion and moderate impact between metal to mineral wearing stresses. It also resists scaling upto temperatures around 300°C and also moderate corrosion.

Apart from applications on mild and medium carbon steels Duroid 650B, being basic coated, can also be used over high carbon and alloy steel base metals and on jobs of thicker cross-section. Requirement of pre-heat can be lowered or avoided altogether to obtain weld deposit free from cracks, porosity and slag inclusions when normal welding practice for basic coated electrode is followed.

**ALLOY BASE:** Fe, Cr, Mn, Mo, V

### **SPECIAL FEATURES**

- Can be used on thicker sections without the need of buffering.

- Smooth arc with low spatter.
- It is very easy to use in all positions. · Excellent weld bead appearance.

### **APPLICATIONS**

Coal cutter blades, rock drills, drill bits, oil expeller worms, cane & bamboo cutting knives, excavator teeth, hot & cold punching dies, bucket lips, dipper teeth, impellers, muller ploughs, chutes, conveyors, shears & croppers, pulping knives, ploughshares, road graders, crusher hammers, caterpillar treads & shoes, etc. This electrode is specially recommended for applications involving metal to mineral wear.

### **PROPERTIES**

Hardness : 57-59 HRC

### **CURRENT RANGE : (AC 70, DC±)**

Size (mm)	Length (mm)	Current Range (Amp)
3.15	450	100-140
4.00	450	120-180
5.00	450	160-250