

ESAB 600B

Self-buffering abrasion resistant deposit

ESAB 600B is a basic coated electrode meant for depositing hard surface having high resistance to wear caused by scouring action or rolling friction. It is insensitive to cracking tendency so the deposit does not require any additional buffering. The weld metal consists of uniformly distributed hard carbides in a martensitic matrix which make this electrode ideally suited for hardfacing parts, subjected to severe service conditions involving a combination of abrasion, moderate impact, and friction.

Transverse relief cracks are welcome in the weld metal.

ALLOY BASE: Fe, Mn, C, Cr

SPECIAL FEATURES

- Excellent weld bead appearance.
- Slag is easily detachable.

- The deposit, hard as it is, can only be finished by grinding.

APPLICATIONS

Used for hardfacing of dredger buckets, draught bucket, working edges and surfaces of earth-moving equipment used in rocky soils, chain link, agricultural implements, vibrating shafts, steel sleeves, hammer mills, press tools, dies, punches and shears, tip of excavator, mill hammers for pulverizing coal & disintegrating chrome ore, iron ore, bucket teeth, shear blades, chutes and conveyors etc.

PROPERTIES

Hardness : 58-61 HRC

CURRENT RANGE : (AC 70, DC±)

Size (mm)	Length (mm)	Current Range (Amp)
3.15	450	85-120
4.00	450	90-160
5.00	450	150-240