



BOR-B

CHARACTERISTICS AND APPLICATIONS:

BOR-B is a rutile coated electrode producing an air hardening type weld metal for hardfacing of carbon and low alloy steels. The weld metal is highly resistant to abrasive wear and has a fair degree of toughness. Ideally suited for applications in which abrasion resistance is required with a fair degree of toughness. Typical applications include brake shoes, shear blades, wheels, cams, gears, pulleys, drive sprockets, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 0.25	0.60	0.40	2.80

HARDNESS (As Welded, After 3 Layers on Mild Steel): 350-400 BHN

CURRENT AND PACKING DATA: AC / DC(-)

Size (mm)	: 5x450	4x450	3.15x450	2.5x350
Dia x Length				
Current Range (Amps)	: 180-220	140-180	100-130	65-90
Qty.(Pcs./Carton)	: 40	70	100	150

APPROVAL: BHEL

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 150°C for one hour.
2. Maintain short arc and avoid weaving.
3. Use suitable buffer layers and preheating, depending on the material composition and thickness.