



BOR-C

CHARACTERISTICS AND APPLICATIONS :

BOR-C is a basic coated electrode producing an air hardening weld metal which has excellent resistance to abrasion or heavy impact or both together. The welds are non-machinable and are ideally suited for applications involving severe abrasion and impact. Typical applications include cane cutting knives, crusher hammers, jaws, rollers, rock drills, tractor grousers, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL(%):

Element	: C	Mn	Si	Cr	Mo	V
Percent	: 0.60	0.70	0.50	6.0	0.25	0.05

HARDNESS (As Welded, After 3 Layers on Mild Steel): 55-60HRC

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x450	4x450	3.15x450	2.5x350
Dia x Length				
Current Range	: 200-250	150-180	100-130	65-90
(Amps)				
Qty.(Pcs./Carton)	: 35	55	75	150

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use short arc and stringer bead.