



CCR-20

CHARACTERISTICS AND APPLICATIONS :

CCR-20 is a special type hardfacing electrode depositing chromium carbide rich weld metal. The electrode operates on AC / DC(+). The weld metal has excellent resistance to severe abrasion with mild impact. Ideally suited for a wide range of hardfacing applications to enhance resistance to severe abrasion, erosion and oxidation. Typical applications include coal crushing hammers, plough shares, drag line bucket lips, tractor grousers, cane knives, rolling mill guides, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr
Percent	: 2.10	0.60	0.70	20.8

WELD METAL HARDNESS: 52-58 RC

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350
Dia x Length			
Current Range	: 200-250	160-200	120-160
(Amps)			
Weight/Carton	: 2.5	2.5	2.5
(kgs)			

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 200-250°C for one hour.
2. Do not deposit more than two layers of CCR-20. In case a heavy build-up is required, use buffer layers with Indotherme electrodes and then continue the build-up for two more layers.