

CH-80R

For soil abrasion

JIS Z3251 DF3B-600-R
DIN E6-60

Applications

Hard-surfacing of cutter knives, liner, mixer-blades and casings.

Characteristics

CH-80R is a titania type electrode which has good slag removal and bead appearance. It is suitable for soil abrasion. Machining is not applicable as welded.

Notes on usage

- (1) Preheat at 150°C and over in general.
- (2) It is desirable to postheat at about 600°C.
- (3) In case of multi-layer build-up welding or welding mother plates with hardening property, under-lay with low hydrogen type electrodes for mild steel.
- (4) Dry the electrodes at 300~350°C for 30~60 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si	Cr	Mo
0.42	0.65	0.89	4.53	1.58

Typical hardness of weld metal

Hv	H _R C
600	55

Size & recommended current range (AC or DC +)

Dia. (mm)	3.2	4.0	5.0	6.0	
L (mm)	350	400	400	450	
Amp.	F	90-130	140-180	190-240	220-300

• Tip Color : Green