

CH-70

For inter-metallic abrasion and light soil abrasion

JIS Z3251 DF2B-500-B
DIN E1-50

Applications

Hard-surfacing of idlers, rollers and truck links of bulldozers.

Characteristics

CH-70 is a low hydrogen type electrode for hard-surfacing machine parts which are subjected to metal to metal abrasion or earth and sand abrasion. It is difficult to do machining.

Notes on usage

- (1) Preheat at 150°C and over in general.
- (2) 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.
- (3) Dry the electrodes at 300~350°C for 30~60 minutes before use.

Typical chemical composition of weld metal (%)

C	Mn	Si	Cr
0.39	1.98	0.52	2.19

Typical hardness of weld metal

Hv	H _R C
520	50

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 : Light Brown