



PRODUCT SELECTION

When compared to similar grades of small diameter alloy cored wires, the Inter-Steel electrodes due to lower dilution rates and extremely high alloy concentrations often give a service life improvement in excess of 300%. Comparative testing shows a swing back from smaller diameter wire to the Inter-Steel Anti-Wear electrodes. Big savings in labour and production result.

Inter-Steel Anti-Wear Grade 2355 Hi-Chrome Carbide Electrode

- Identification Light Blue End Tip
- No buffer layers needed. Gives good abrasion and moderate impact resistance.
- For application to dredge buckets, crusher rolls, ripper tynes, crusher hammer,
- AC-DC currents. 6mm good for out of position hard facing
- Amperages: 6mm 85-135, 8mm 130-190, 12mm 200 430

Inter-Steel Anti Wear Grade 2360 Chrome Moly Carbide Electrode

- Identification: Orange End Tip
- Composition: Carbon, Chromium, Manganese, Molybdenum, Silicon & Vanadium
- Very good abrasion resistance
- Typical applications include: Conveyor Screws, Dredge Pump Liners, Agricultural Tynes and Discs
- Deposits relief check, multi layer may be used
- AC-DC currents
- Hardness 57-60 HRC
- 6mm very good for overhead and vertical Hard facing
- Amperages: 6mm 80-120, 8mm 120-175, 12mm 195-425

PACKING

The Inter-Steel Hardfacing Electrodes are supplied in the following sizes:

- 5 Kg
- 20 Kg
- 25 Kg

Tubular Hardfacing Electrodes-Typical Weld Metal Analysis

Inter-Steel 2355	C	Cr	Mn	Fe
Minimum	4.40%	32.00%	0.20%	Bal
Maximum	6.00%	40.00%	0.60%	Bal

Hardness	HRC
Single Layer	55 - 60
Multiple Layers	58 - 64

Inter-Steel 2360	C	Cr	Mn	Mo & Nb	B	Fe
Minimum	4.10%	25.00%	1.00%	1.30%	0.30%	Bal
Maximum	5.20%	35.00%	2.10%	2.50%	0.60%	Bal

Hardness	HRC
Single Layer	54 - 60
Multiple Layers	58 - 64