



MODI XL H.A. HARD FACING ELECTRODE

CHARACTERISTICS : A special electrode, with basic type of coating, designed for surfacing of parts subject to heavy abrasion. Arc is very stable and smooth which ensures proper alloy transfer to weld deposit. Weld beads are flat and smooth. Slag is easily detachable. Performance is equally good on AC as well as on DC (+).

APPLICATIONS :

- Excavator Teeth
- Oil Expeller Worms
- Crushing Hammers
- Muller Tyers
- Plough Shares
- Cranes Wheels
- Cams
- Cement Die Rings

RECOMMENDATIONS : To get optimum results re-dry electrodes at 350°C for one hour or at 250°C for two hours. Use stringer bead technique and sequence welding to control the rate of cooling. Use short arc and lower currents of the recommended range.

CHEMICAL ANALYSIS OF WELD METAL (%) :

	C	Mn	Si	Cr
	2.0-3.0	0.8-1.25	2.0-3.5	3.5-5.5

HARDNESS : ON THREE LAYER DEPOSIT : 525-600 BHN

CURRENT CONDITIONS : USE AC (50V) OR DC (+)

Size (mm)	3.15 X 350	4.0 X 450	5.0 X 450
Range (Amps.)	100-130	140-180	190-230



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Manufactured under licence from :
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