

UPW-626

Hardfacing open arc welding wire

Features	A high Carbon high Chromium alloy designed to withstand high stress grinding with low impact. Due to containing a lot of chromium carbides in the microstructure, the weld deposit is non-machinable.	
Applications	The reclamation of worn Ni-hard or high chromium cast iron rollers in grinding mill, coal crusher and table segments in coal firing power stations and vertical mills in cement plants.	
Typical Chemistry	C 5.5%, Mn 0.7%, Si 0.8%, Cr 27%	
Hardness	54 ~ 64 HRC (undiluted deposit)	
Size	2.8 mm	
Package	Drum packing in 250 kg	
Recommended welding parameters	Voltage	27 ~ 32 V
	Current	250 ~ 450 A
	E.S.O.	25 ~ 35 mm