



Elgaloy Hard 100

REPAIR & MAINTENANCE

Other

Date: 2007-10-19
Revision: 13

Description:

Elgaloy Hard 100 is a high recovery electrode, producing a weld metal deposit extremely rich in chromium carbides which is highly resistant to abrasion but exhibits limited impact resistance. Ideal for hardsurfacing components used in the mining and quarrying industries. Good wear and corrosion resistance at elevated temperatures. Surface cracking is normal and can be reduced by preheating to 250-450°C. A buffer layer of Elgaloy Mix 18 is recommended for heavy build-ups or surfacing 13% Mn steels to prevent crack propagation into base material. Deposits are not machinable but can be ground. Also available as a self-shielded flux cored wire, Elgaloy Hard R 100 and as a flux coated tubular electrode, Elgaloy Tube 100, designed to give high deposition rates at very low welding currents.

Guide for usage:

The electrode is preferably to be used with DC+, to create a thick build up also AC is possible to use.

Applications:

Excavator teeth, dredger bucket lips, sizing screens, rollers, screw conveyors, scraper and mixer blades, crusher jaws and hammers, chutes, agriculture implements, rolling mill guides sinter plant.

Welding positions:



Shielding gas:

Coating type:

Special

Metal recovery:

175 %

Hardness as welded:

58-61 HRC, 700 - 740 HV10

Welding current:

DC + (AC)

Chemical composition, wt.%

	C	Cr	Mo	V
Min	3,0	29,0	0,45	0,30
Typical	3,5	30	0,5	0,4
Max	4,5	32,0	0,6	0,50

Classification:

DIN 8555-83

E10-UM-65-Z

Approvals:

Product data

Diam.mm	Product code	Current A	Voltage V	Delivery form
3,2	70343210	115-140		
4,0	70344010	140-190		