

30 RC

ALLOY FOR RECONSTRUCTION WORK WITH CARBON STEEL. IT IS HIGH IMPACT AND MODERATE ABRASION RESISTANT

APPLICATIONS: This is a special welding rod for reconstructions in carbon steel parts. It has high compression resistance and moderate abrasion resistance. It is used to clad sprockets in tractors, rollers in steel mills, etc. It is also used to prepare the surface before hard cladding with carbon steel.

CHARACTERISTICS: 30RC welding rod has a low hydrogen content and powder iron covering for applications with AC or DC reverse polarity. It is specially suitable for reconstructions in carbon steel parts.

Its filler metal is within the machinable range. It is ideal to prepare the surface for subsequent cladding with extremely hard materials. It withstands high impact wear and is resistant to deformation.

Its low hydrogen content and powder iron covering allows fast cladding operation resulting in pore and crack free filler metal deposits. Filler metal can be red hot forged.

PROCEDURE: Clean the joint area. Preheating is not necessary since you can use a higher AMP with this welding rod to allow proper fluency of the filler metal. Use a medium arc and remove all the slag between one pass and the next. Make rows of weld beads or woven weld beads not wider than twice the diameter of the welding rod. Where abrasion resistant surfaces are required, you should start by surfacing the part with Vilchis 60RC or HS-2.

ROCKWELL HARDNESS "C":	1ST PASS 20 TO 25° , 2ND PASS 25 TO 35°
POSITIONS:	ALL
CURRENT:	DC REVERSE POLARITY or AC
ABRASION RESISTANCE:	MODERATE
IMPACT RESISTANCE:	EXCELLENT

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	Cr	Mo	Mn	Si	Ni	3.25 mm - 1/8"	110-130
0.23	0.40	0.40	1.20	0.50	1.20	4.0 mm - 5/32"	140-175
						5.0 mm - 3/16"	230-300