

60 RC

WELDING ROD WITH LOW HYDROGEN COVERING. CHROMIUM, MANGANESE, MOLYBDENUM AND CARBON CONTENT TO WITHSTAND ABRASION AND IMPACT WEAR.

APPLICATIONS: It is used in plow shares, drill bit tips, mixing blades, tilling machinery, pump impellers, and in many other applications where top hardness is required as well as good wear resistance to abrasion and impact.

CHARACTERISTICS AND PROCEDURE: 60 RC is a welding rod with a low hydrogen content covering. It is specially recommended to clad parts submitted to wear by abrasion and impact. Its filler metal is both hard and homogeneous. This alloy contains carbon, chromium, molybdenum and silicon. It reaches a hardness degree of up to 55° Rockwell C. The special low hydrogen content covering allows to make thick cladding without the risk of cracks or bursts in the filler metal deposits. Its filler metal deposits can be forged to hot red temperatures and they will retain their hardness once the metal cools down. This welding rod is to be used like a standard electrode with low hydrogen content since no special technique is required to achieve filler metal deposits which are pore free and smooth. The slag is easily removed. Grind the joint area till it is clean. There is no need for special welding techniques but simply keep the arc short as it is the case with low hydrogen content covered electrodes. It will be necessary to heat the part and then, to let it cool down slowly. Apply the weld to broad areas and with little thickness since thick cladding tends to develop transversal cracks.

ROCKWELL HARDNESS "C":	1st WELD BEAD 45 TO 50, 2nd WELD BEAD 50 TO 55
POSITIONS	ALL
CURRENT:	AC OR DC REVERSE POLARITY
ABRASION RESISTANCE:	EXTREME
IMPACT RESISTANCE:	MODERATE
MICROSTRUCTURE:	MARTENSITIC STEEL

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Cr	Mn	Mo	Si	3.25 mm - 1/8"	100-125
0.65	4.0	1.0	0.50	0.80	4.0 mm - 5/32"	130-160
					5.0 mm - 3/16"	155-230