

HS-3

WELDING ROD TO CLAD STEEL SUBMITTED TO HEAVY DUTY OPERATION CONSISTING ON ABRASION, IMPACT, FRICTION AND SEVERE CORROSION.

APPLICATIONS: This is a welding rod whose filler metal is abrasion and/or erosion and/or cavitation resistant plus friction and severe corrosion resistant. It is used in the mining, the cement and the sugar industries, for example, in stone mill parts, excavation machinery, concrete mixers, dredgers, stone crushing equipment, mixing blades, cat crawl buckets, mill parts and also for those parts submitted to abrasion, heat and corrosion.

CHARACTERISTICS AND PROCEDURE: Vilchis HS-3 consists on a formula which combines a special alloy with excellent abrasion, impact and corrosion resistance. Its filler metal can be highly polished. Its filler metal deposits cannot be machined and retain their original hardness up to 800°C. This welding rod is easy to apply and to control.

Clean the joint area. Keep the arc medium with a little weaving motion. A longer arc is recommended whenever wider and shallower filler metal deposits are required. Care should be taken not to overheat the base metal since it decreases hardness due to dilution. If more than two layers of cladding are required to restore the part original dimensions, you should use Vilchis 30 RC for the intermediate layer.

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| ROCKWELL HARDNESS "C": | BETWEEN 56 AND 62 RC |
| POSITIONS: | ALL |
| CURERNT: : | AC or DC REVERSE POLARITY |
| IMPACT RESISTANCE: | MODERATE |
| ABRASION RESISTANCE: | EXCELLENT |

| FILLER METAL CHEMICAL ANALYSIS % | | | | | SIZES | AMPERAGE |
|----------------------------------|-------|------|------|------|----------------|----------|
| C | Cr | Mo | W | V | 3.25 mm - 1/8" | 100-130 |
| 4.80 | 23.96 | 8.33 | 2.08 | 1.04 | 4.0 mm - 5/32" | 160-180 |
| | | | | | 5.0 mm - 3/16" | 200-250 |