

TA 4

Specially designed for exceptional resistance to severe fine abrasion and erosion at elevated temperatures

ALLOY BASIS

Cr, C, Mo, Nb, W, V

PROPERTIES

- Complex carbides of Cr, Mo, Nb, W and V in hard austenitic matrix resist hardfacing parts subject to severe abrasion / erosion with moderate impact at elevated temperatures upto 800°C.
- Deposits have uniformly dispersed complex carbides in austenitic matrix.
- Structure : Cr carbides in austenitic matrix.
- Non-machinable.
- High chromium carbide.

TECHNICAL DATA

Hardness : 67 RC

TYPICAL APPLICATIONS

- C. R. Fans
- Conveyer flights
- Buckets
- Pump bodies
- Paddles

PROCEDURE

Surface should be cleaned by grinding and wire brushing. A gouging electrode may sometimes be used to remove damaged metal. Preheating to 200 to 300 °C is sometimes recommended for high carbon steels, alloy steels and cast irons. Relief checking is normal and desirable. Austenitic manganese steels should not be preheated.

WELDING CURRENT

Current : DC (±) / AC (70 V)
Size (mm)/Length : 6.3x450 8.0x450 10.0x450
Current (amps) : 90-130 130-175 170-200



Reclamation, Fusion
Surfacing & Spraying Solutions

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