PRODUCT DATA SHEET

ArcoHard 665 – SS (self– shielded)

ArcoHard™ is a family of alloys suited to Build up and reclamation to specific Hardness. Machinable or protective layers "As Welded" (Controlled welding conditions).

CLASSIFICATIONS	AS/NZS 2576-2005, 1125-B7 EN 14700 T Fe1 250 P

ArcoCrush 665 is a cored arc welding hardfacing wire manufactured from high grade ferro-alloy additives and manufactured to exact formulation providing excellent weld characteristics and service performance.

Suited to self- shielded (SS) hardfacing or heavy build up work, the weld deposit contains a low Alloy Bainite microstructure with mild impact resistance, low abrasion resistance and hardness up to 265 Hb / 28 HRc.
Suitable for repair work, final layering can be applied using a range of higher alloy hardfacing products suited to service applications or targeted wear management. Weld deposit can be left as welded or easily machined to profile.
Preheating and slow cooling is recommended for multiple layers to avoid hardening above 265Hb, also to avoid possible relief checking.
Used for Heavy build-up or reclamation of components subject to metal to metal abrasion, friction or wear / abrasion by sand, clay, mud, vegetation. Excellent for applications of sliding action between ferritic steels.

Applications

Undercarriage and track equipment components such as Idlers, rollers, sprockets, track pads, shafts, gears. Crane rope drums/sheaves, Mining equipment refurbishment of fixed and mobile plant component. Forestry equipment, Railway track and equiupment.

Post weld Relief checking may occur without preheat.

Gas shielding not required for self-shielded wire, torch electrode Positive polarity (DCEP)

Typical All- weld Metal Composition (Weight%)

C	Mn	Si	Cr	Fe
0.11	1.6	0.30	1.1	Balance

Typical All- weld Metal Hardness range

25-28 HRc (3 layer)
250 - 265HB

PACKAGING
15kg, 25kg coils, Drums 300kg

Wire diameter Sizes
1.2mm, 1.6mm, 2.8mm, 3.2mm