



PRODUCT DATA SHEET



ArcoHard 765 – 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, 1435-B7 EN 14700 T Fe1 350 P
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ArcoCrush 765 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, the weld deposit contains a tough Bainite microstructure with good impact resistance, moderate abrasion resistance. Suitable for metal to metal wear and hardness up to 360 Hb / 39 HRc. 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 360Hb, also to avoid relief checking.

Used for Heavy build-up or reclamation of components subject to metal to metal abrasion, friction or wear caused by 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 equipment.

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	Mo	Cr	Fe
0.12	1.4	0.60	0.4	1.7	Balance

Typical All- weld Metal Hardness range

32-39 HRc (3 layer)
320 - 360 HB

PACKAGING

15kg, 25kg coils, Drums 300kg

Wire diameter Sizes

1.2mm, 1.6mm, 2.8mm, 3.2mm