



## PRODUCT DATA SHEET



### ArcoHard 865 – 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).

<b>CLASSIFICATIONS</b>	AS/NZS 2576-2005, 1440-B7 EN 14700 T Fe1 400 SP
------------------------	--

ArcoCrush 865 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 Pearlitic/ martensitic microstructure with good impact resistance, moderate abrasion resistance. Suitable for metal to metal wear and hardness up to 420 Hb / 44 HRc. Weld deposit can be left as welded or machined to profile.

Preheating and slow cooling is recommended for multiple layers to avoid hardening above 420Hb, also to avoid relief checking.

Used for build-up or reclamation of components subject to metal to metal abrasion, friction or wear caused by abrasion by sand, clay, mud, vegetation.

### 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.

Post weld Relief checking is normal 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
0.21	2.1	0.90	0.5	3.3	Balance

### Typical All- weld Metal Hardness range

42-44 HRc (3 layer)
400-415HB

#### PACKAGING

15kg, 25kg coils, Drums 300kg

#### Wire diameter Sizes

1.2mm, 1.6mm, 2.8mm, 3.2mm