

PRECEMAY

TUBULAR HARDFACING ELECTRODES

PRECEMAY tubular hardfacing electrodes are designed exclusively for highly abrasive applications. Operated under a lower current they provide less distortion, no burn through and higher deposition rates. A high alloy yield is achieved, with a low heat input and no de-slagging between runs is required.

All three sizes - **6mm, 8mm, 11mm** - can be used out of the same holder due to a standard stub end and tubular electrodes are resistant to moisture so therefore no special storage is needed. With a wear performance of up to 10 times better than standard electrodes, our tubular hardfacing facing electrodes are the perfect partner for overlay plate and special steels.

COMPARATIVE WELD METAL DEPOSITION DATA					
PROCESS	SIZE MM	AMPS	VOLTS	KG/HR	ALLOY YIELD %
STANDARD EXTRUDED ELECTRODE	4	180	24	1.62	46.80
	5	250	25	2.01	46.80
HIGH RECOVERY EXTRUDED ELECTRODE	4	240	25	2.25	60.00
	5	350	26	3.50	60.00
TUBULAR HARDFACING ELECTRODES	6.0	80	28	3.25	83.00
	8.0	140	29	4.25	83.00
	11.0	190	30	5.00	83.00



TUBULAR HARDFACING ELECTRODES																				
GRADE	DIAMETER - MM			WELD METAL ANALYSIS %									HRC	ABRASION	IMPACT	TEMPERATURE	APPLICATIONS			
	6.0	8.0	11.0	C	Cr	Si	Mn	B	Mo	Nb	V	W								
A10	✓	✓	✓	3.1	10.0								52.0	64-68	*****	*	***	Drill Collars	- Mixer Blades	- Worm Screws
A12	✓	✓	✓	2.8	12.0								40.0	64-67	*****	**	***			
A23	✓	✓	✓	5.0	22.0				6.0	6.0	1.0	2.0	58-64	*****	***	*****	- Furnace bells - Hoppers	- Kiln wear parts - Clinker plates	- Crusher hammers - Fan Blades	
A33	✓	✓	✓	5.5	40.0		0.5						50-60	***	***	***	- Crusher mantles - Blow bars	- Muller pan tyres - Shovel fronts	- Mixer blades - Earth moving	
A35	✓	✓	✓	4.0	27.0		4.0	0.5	4.0		1.0		50-60	*****	***	***	- Incinerator - Knives	- Compactor wheels - Crushing equipment		
A37	✓	✓	✓	4.0	26.5	1.5	0.8		0.9	7.9			55-61	*****	*****	*****	- Hammers - Mills	- Cement Works - Wear plates	- Screw Conveyors	
A108	✓	✓	✓	0.8	15.0	0.8	14.5						50-52	***	*****	**	A perfect buffer layer prior to A33 / A35			

6.0 mm - 13 electrodes per kg / 8.0 mm - 7 electrodes per kg / 11.0 mm - 4 electrodes per kg

PRECEMAY FZE

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