

# ROWELD-HF III LH

BASIC COATED LOW HYDROGEN TYPE HARD FACING  
ELECTRODE

BASIC ALLOY: C, FE, CR, MO, V  
DIN-8555: E1-UM-60-S  
EN ISO 14700 E FE-8

## KEY FEATURES:

A medium heavy coated hydrogen controlled, iron powder, air hardening type hard facing electrode with weld deposits are hard and cannot be machined. Weld dressing is possible by grinding, can withstand friction and moderate impact.

## APPLICATIONS

- Suitable to work on high carbon and high sulphur steels without cracks.
- Crane wheels, drill bits, crusher hammers, shear blades, rock drill cane cutting knives.
- Impellers, oil expeller worms, conveyor buckets, sockets etc.
- Unique in its versatility of applications in areas of building-up worn out parts and hardfacing

## RE-DRY CONDITION:

- Re-Dry the electrode at 250°C for one hour.

## CHEMICAL COMPOSITION:

C	Mn	Si	Cr	Mo	V
0.50-0.80	1.00 Max	0.75 max	6.00-8.00	0.40-0.60	0.20-0.40

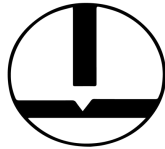
## MECHANICAL PROPERTIES:

Hardness

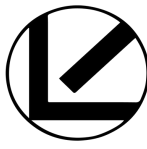
550-650 BHN

## WELDING POSITION

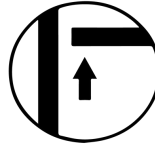
1G/1F



2G/2F



3G UP



## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+) Amps	Kg/pkt.	Kg/Case
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	150-180	5	20
5.00	3/ 16"	210-260	5	20