

Wearshield® 60(E)

Key Features

- A basic coated downhand 200% recovery electrode that produces a primary carbide weld deposit
- Ideal for severe abrasion, limited to 2 layers
- Non machinable deposit, grinding only
- Deposits will show relief checking
- The electrode coating facilitates easy arc control and arc visibility whilst maintaining a short arc

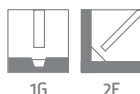
Typical Applications

- Crusher rolls and cones
- Bucket /Shovel teeth and lips
- Brick and cement mill parts
- Earth moving equipment, ripper teeth, power shovels, crushing equipment, etc

Conformances

AS/NZS 2576: 2360 A4*
EN 14700: E Fe15
 (nearest equivalent)

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	400502SRP-1	SRP

Mechanical Properties

Rockwell – HRc		
	1 Layer	2 Layers
Typical Results	57-60	60-62

Deposit Composition

	%C	%Si	%Cr
2 or more layers	5.0	3.5	35

As welded microstructure consists mainly of primary chromium carbides in an austenite-carbide eutectic matrix

Typical Operation Procedures

Current (amps)		
Polarity	3.2mm	4.0mm
DC+	110-150	140-180

ADDITIONAL INFORMATION

When welding with Wearshield 60 stringer beads should be employed. Weaving is not advised since wide weaves generally increase the check crack spacing which can result in deposit spalling. The as-welded deposit readily check cracks. Preheat is not necessary when surfacing austenitic substrates such as stainless steels and manganese steels, although the interpass temperature

should be limited to about 260°C for manganese steels. The deposited weld metal is not machinable. The deposit thickness is usually limited to 2 layers. For applications requiring build-ups in excess of 2 layers, buttering layers of 307 alloy, Wearshield BU-30 should be used prior to Wearshield 60. Alternatively, a preheat of 650°C can be used to eliminate the formation of check cracks.