

METHARD 650

MMA HARDFACING ELECTRODE OF NOMINAL 650HV HARDNESS

PRODUCT DESCRIPTION

Rutile metal powder flux on a low carbon core wire.
Recovery is about 120% with respect to core wire, 65% with respect to whole electrode.

SPECIFICATIONS

BS EN 14700 E Fe2 (Nearest classification)

ASME IX QUALIFICATION

QW432 F-No

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Mo	V
Typical	0.7	0.6	0.4	8	0.6	0.5

ALL-WELD MECHANICAL PROPERTIES

Typical hardness as-welded on mild steel base plate:	1 layer	3 layers
Vickers (HV)	600-700	700-760
Rockwell (HRC)	55-60	60-63

Preheat and dilution will affect hardness in the first two layers but will have little effect in subsequent layers.

OPERATING PARAMETERS, DC +VE OR AC (OCV: 45V MIN)

Diameter (mm)	3.2	4.0	5.0
min. A	80	100	140
max. A	140	180	240

PACKAGING DATA

Diameter (mm)	3.2	4.0	5.0
Length (mm)	450	450	450
kg/carton	18.6	18.6	19.5
Pieces/carton	387	246	171

STORAGE

3 hermetically sealed ring-pull metal tins per carton, with unlimited shelf life. Direct use from tin is satisfactory.

For electrodes that have been exposed:

Redry 200 – 300°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total.

Storage: Recommended ambient storage conditions for opened tins (using plastic lid): < 60% RH, > 18°C.

FUME DATA

Fume composition, wt % typical:

Fe	Mn	Cr	Mo	V	F	OES (mg/m ³)
20	6	2.5	0.1	0.5	18	2