

# GRIDUR - 555

## IDENTIFICATION

Gridur 555

## DESCRIPTION

A medium-heavy-coated, basic type, hard facing electrode. The weld deposit is alloyed cast iron, which is hard, and extremely resistant to abrasion and metal-to-metal wear. The weld metal is so designed

as to be especially resistant to scratching abrasion and to occasional grinding abrasion. The built-up surface does not deteriorate through furrowing, local plastic flow and micro cracking.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr
2.10 - 2.90	0.80 - 1.20	2.2 - 3.60	0.03 max	0.03 max	2.90 - 4.0

## TYPICAL APPLICATIONS

Oil expeller worms, concrete mixer blades, scrapper blades, screw conveyors, cement die rings Muller tyres, ploughshares, dippers, excavator teeth, etc.

**HARDNESS OF THE WELD METAL** : On 3-layer Deposit : 575 - 600 BHN

## PACKING PARAMETERS

Size (mm)	Length (mm)	Amps AC / DC (+)	Packing / Box (kg)
2.5	350	70 - 90	5 x 4 = 20
3.15 / 3.20	450	90 - 120	5 x 4 = 20
4	450	110 - 150	5 x 4 = 20
5	450	150 - 200	5 x 4 = 20