

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 |