Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

# SELECTRODE 1675

**Chromium Carbide**

## INTERNATIONAL CLASSIFICATION

**AWS/ASME NONE**
**DIN 8555: E10-55r**

## FEATURES & APPLICATIONS

This alloy is used for protecting most iron base surfaces against severe abrasive wear and medium impact. The hardness and resistance to impact make this electrode suitable for use in a large variety of applications which include sugar mill roll roughening, crusher cones and mantels, swing hammers, excavator buckets lips and teeth, dragline buckets, conveyor screws, rock chutes etc.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

| C | Ni | Mn | Cu | Si | S | P | Cr | Fe |
|---|---|---|---|---|---|---|---|---|
| 4.4 | .15 | 2.5 | .14 | 1.3 | .017 | .014 | 33 | Bal. |

Flux Color: Black

## TYPICAL MECHANICAL PROPERTIES

| **Undiluted Weld Metal** | **Maximum Value Up to:** |
|---|---|
| Hardness | Rockwell C52-59 |
| | Vickers 565-727 |

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+) or AC

| Diameter (mm) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|---|---|---|---|
| Minimum Amperage | 90 | 130 | 180 |
| Maximum Amperage | 140 | 200 | 250 |

**Welding Techniques:** Use a stringer or wide weave technique. Deposit a maximum of 2 to 3 passes to achieve full hardness.

**Welding Positions:** Flat, Horizontal

**Deposition Rates:**

| Diameter (mm) | Length (mm) | Weldmetal/ Electrode | Electrodes per lb (kg) of Weldmetal | Arc Time of Deposition min/lb (kg) | Amperage Settings | Recovery Rate |
|---|---|---|---|---|---|---|
| 1/8 (3.25) | 14" (350) | 1.1 oz (31g) | 14 (30) | 23 (50) | 120 | 180% |
| 5/32 (4.0) | 14" (350) | 2.7 oz (76g) | 6 (14) | 17 (37) | 175 | 180% |
| 3/16 (5.0) | 14" (350) | 4 oz (112g) | 4 (9) | 13 (29) | 230 | 180% |

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

| Diameter (mm) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|---|---|---|---|
| Length (mm) | 14" (350) | 14" (350) | 14" (350) |
| Electrodes / lb | 9 | 6 | 4 |
| Electrodes / kg | 20 | 13 | 9 |