

## Inter-Weld Tubular Hardfacing Electrodes

### PRODUCT SELECTION

When compared to similar grades of small diameter alloy cored wires the Inter-Weld electrodes due to lower dilution rates and extremely high alloy concentrations often give a service life improvement in excess of 300%. Comparative testing shows a swing back from smaller diameter wire to the tubular Inter-Weld type hardfacing electrodes. Big savings in labour and production result.

### PACKING

The Inter-Weld hardfacing grades are packed in 5kg, 20kg and 25kg cartons.

### INTER-WELD ANTIWEAR GRADE 2355

- Identification Light Blue End Tip
- No buffer layers needed. Gives good abrasion and moderate impact resistance.
- For application to dredge buckets, crusher rolls, ripper tynes, crusher hammer,
- AC-DC currents. 6mm good for out of position hard facing
- Amperages: 6mm 85-135, 8mm 130-190, 12mm 200 430

### INTER-WELD ANTIWEAR GRADE 2360

- Identification Orange End Tip
- Very good abrasion resistance.
- Recommended applications include conveyor screws, dredge pump liners, agricultural tynes, discs, Deposits relief check, multi layer may be used
- AC-DC currents.
- 6mm very good for overhead and vertical hard facing
- Amperages: 6 mm 80-120, 8mm 120 -175, 12 mm 195-425

### INTER-WELD ANTIWEAR GRADE 2460

- Identification Red End Tip
- Modular formed carbides give both good impact and abrasion resistance to wear. Less relief checking than 23series. Ideal for rail ballast tampers, crusher hammers, dredger teeth, ripper teeth, grizzly bars, steel guides
- AC-DC currents. 6mm very good for out of position hard facing
- Amperages: 6mm 90-130, 8mm 135-185, 12mm 200-430

### Typical Weld Metal Analysis

INTER-WELD 2355	C	Cr				Fe	
Minimum	4.40%	32.00%	0.20%			Balance	
Maximum	6.001/6	40.00%	0.60%			Bat	
Hardness	Single Layer			55- 60 HRC			
Inter-Weld 2360	Multiple Layers			56- 64 HRC			
KIDS 2360	C	Cr	Mn		Mo&Nb	B	Fe
Minimum	4.10%	25.00%	1.00%		130%	0.30%	Bat
Maximum	5.20%	35.00%	2.10%		2.50%	0.60%	Bat
Hardness	Single Layer			54- 60 HAC			
	Multiple Layers			56- 64 HRC			
Inter-Weld 2460	C	Cr		Si	Mo & Nb	Fe	
Mimum	4.00%	24.00%	0.50%	0.50%	6.00%	Bat	
Maximum	5.20%	31.00%	170%	180%	9.00%	Bat	
Hardness	Single Layer			55- 61 HRC			
	Multiple Lays			60- 66 HRC			