

GM 55 R

HARD SURFACING ELECTRODE

Description:

A medium alloy surfacing electrode depositing air hardening type of weld metal which has excellent resistance to severe abrasion and moderate impact. The electrode is very easy to use and gives smooth weld surface. The deposit is non-machineable and can be shaped by grinding.

Applications:

- ❖ Crusher jaws, Crusher hammers
- ❖ Heavy earth moving equipment.
- ❖ Punches, Dies
- ❖ Conveyor parts, Cane cutting knives
- ❖ Shear blades, Paper cutting knives

Chemical Composition of Weld Metal (WT. %):

C	Mn	Si	Cr	Mo
0.40 - 0.60	0.60 - 1.0	0.80 max	5.0 - 8.0	0.50 max

Mechanical Properties of Weld Metal:

Hardness (BHN) on two layer deposit
500 – 550

Current Conditions: AC/DC (+)

Size (mm)	3.15 x 450	4.00 x 450	5.00 x 450
Current (Amps)	100 - 130	140 - 180	190 - 230

Welding Positions: Flat

Recommendation:

- ❖ Keep electrodes dry. In case of moisture pick-up re-dry the electrodes at 150 °C for one hour.
- ❖ Use low current, short and minimum weaving of electrodes.
- ❖ For thick deposits on austenitic manganese steel components, GM –Mn electrode should be used for buffer layers.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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