

PRODUCT DATA SHEET

HARDFACING ELECTRODES

PH600



SUMMARY

- > A heavy coated iron powder electrode
- > Versatile, low cost hard facing deposit
- > Self hardening

IDENTIFICATION

Coating - Grey **Tip** - Pink **Imprint** - PH600

CLASSIFICATION

- > AS/NZS 2576 1855-A4

DESCRIPTION AND APPLICATION

The Weldwell PH600 is a heavy coated iron powder electrode which deposits a weld metal containing carbon chromium and manganese. This resultant deposit is martensitic, containing finely divided chromium carbides which are highly resistant to abrasive wear, and also have very good properties against sliding and rolling friction.

Suitable for welding bull dozer blades, excavator teeth, plough shears, bucket teeth and lips.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
3.2	380	90 - 130
4.0	380	140 - 180

*Recommended for DC +/- or AC (minimum 50 OCV).
Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr
0.40	0.3	0.5	8

TYPICAL ALL WELD METAL HARDNESS

Metal Hardness	55 - 59 RC
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PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER KG	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
3.2	5.0	3	133	PH60032
4.0	5.0	3	67	PH60040

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Weldwell expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Weldwell.

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