

PRODUCT DATA SHEET

HARDFACING ELECTRODES

PH700



SUMMARY

- > Deposits a high chromium, high carbon type alloy
- > Can be deposited directly on to mild steel, low alloy steel or austenitic manganese steel

IDENTIFICATION

Coating - Black **Tip** - Red **Imprint** - PH700

CLASSIFICATION

- > AS/NZS 2576 2360-A4

DESCRIPTION AND APPLICATION

The Weldwell PH700 is a high carbon-chrome type of electrode for impact and severe abrasion and has good resistance to scaling and corrosion in high temperatures. It can be deposited directly on to mild steel, low alloy steel or austenitic manganese steel. However, when the base metal is harden-able or high alloy, a buffer layer of PH56S, PH77 or the stainless alloy RSP may be necessary. Typical undiluted hardness 62Rc.

Suitable for welding furnace parts, rolling mill guides, conveyor screws, dozer blades, ripper teeth etc.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
3.2	380	110 - 130
4.0	380	130 - 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
3	18

TYPICAL ALL WELD METAL HARDNESS

Metal Hardness	60 - 64 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	86	PH70032
4.0	5.0	3	57	PH70040

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