

## R-650

### **Basic coated hydrogen controlled Hard facing electrode**

**Basis OF Alloys** : C, Fe, Cr, Mo, V

**Application & Descriptions :** R- 650 B electrode operates in all positions with excellent welding characteristics, evenly rippled, porosity and cracks free, hard deposit economical for overlays, without the depositing buffer layer.

It is versatile electrode for hard surfacing application on variety of parts, subject to heavy abrasive wear and as a final layer on Manganese weld deposit and parts to reduce the initial

**RE-DRY CONDITION** : Re-Dry the electrode at 350°C for 1 hour,

#### **ALL WELD MECHANICAL PROPERTIES (TYPICAL):**

HARDNESS
AS WELDED 600 BHN

#### **DIEMENSION, CURRENT CONDITION & PACKING DATA:**

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/- AC) Amps	weight of packet (Kgs)	Weight of Case
2.50x350mm	3/32"X14"	50-80	5	20
3.20x350	1/8"X14"	70-110	5	20
4.00x350	5/32"X14"	100-130	5	20
5.00X350	3/16"X14"	130-160	5	20

Customer packing on request.