



HARDFACE 700 ELECTRODE

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION;

Hardface 700 is our most popular Hardface electrode used for severe abrasion and considerable impact. Weld deposits have a martensitic structure that resists wear even in Metal-to-metal mild steel contact. Hardface 700 is most commonly used on plowshares, dredger, cultivator shoes, cutter knife, bucket teeth and lips, well drilling bits, cement mixer blades, shovel tracks and screw conveyors.

TYPICAL WELDING PROCEDURES; RECOMMENDED AMPERAGE (AC OR DC+)

Diameter	Amps (Flat)	Volts	Diameter	Amps (Flat)	Volts
1/8"	90-130	24-28	3/16"	180-240	25-32
5/32"	140-180	25-31	1/4"	220-300	25-34

PROCEDURES Use AC or DC+. Preheating is not required except on alloy steels and helpful in general 300°F. Using the weaving technique and keeping a short arc length, deposit up to 1/4" maximum. If more than two passes will be required, it is suggested that a "padding layer" of Buildup 300 or Tensileweld be used prior to depositing Hardface 700.

CHARACTERISTICS When used in the flat and horizontal positions, this electrode will exhibit a stable arc and produce weld deposits that are very smooth and finely rippled. Hardness as deposited: RC57-62

Procedures are based on flat position and may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY AND PROPERTIES;

Carbon	0.48	Manganese	1.38
Silicon	1.41	Phosphorus	0.015
Sulphur	0.007	Molybdenum	0.04
Chromium	3.85		

Hardness Rockwell C = 57-62

AVAILABLE SIZES: TH 700 1/8, 5/32, 3/16, 1/4

Other sizes available – please inquire

SPECIFICATIONS; Internal ; JIS Z 3251-2000, DF2B-700-B ; KS DF2B-700-B

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2020 DC

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