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Covered Electrode for Direct Hardfacing on Cast Irons

M H － 5 0 0 S

■ Standard –
■ Covering Low Hydrogen Type
■ Tip Color Red

■ Application

MH-500S can use for hardfacing of the mold and the area which is subjected to high contact pressure and sever or abrade severely

■ Features

1. MH-500S is the covered electrode for direct hardfacing on the cast iron base metal.
2. The hardness of the first layer of the deposited metal is kept low to prevent crack. In the third layer, the deposited metal shows stable hardness, HRC45～50.

■ Welding Procedures

1. Preheating is not required but welding at proper preheating and interpass temperature, 150～200℃, is very efficient to prevent crack. Over preheating and too high interpass temperature rises the risk of crack because of increasing of penetration to the base metal.
2. Keep bead length between 80～120mm and do peening just after each bead is finished.
3. Keep arc length as short as possible, weld by stringer bead and apply appropriate electric current. These prevent over dilution to the base metal.
4. Apply back step welding or start welding from outside of target area to avoid blowhole at starting part.
5. The electrode should be re-dried for 30～60 minutes at over 300℃ before use.

■ Typical Hardness of the Deposited Metal as welded (at the third layer of direct hardfacing on the cast iron base metal)

HV	HRC	HS
440～510	45～50	59～66

■ Appropriate Welding Current (AC or DCEP)

Diameter (mm)	2.6	3.2	4.0
Length (mm)	300	350	400
Current (A)	50～80	70～90	80～110
Min. Quantity (Kg)	3.0	5.0	5.0

Equivalent to wire for MAG welding:(MH-400S)
Equivalent to electrode for TIG welding: OMH-5T