



DUROID 250

Machinable deposit for build-up before hardfacing

A smooth running rutile coated general-purpose hardfacing electrode, depositing a tough air-hardening chrome-manganese alloy weld metal, suitable for resisting moderate abrasion and impact.

SPECIAL FEATURES:

- Smooth arc with low spatter.
- Excellent weld bead appearance.
- Deposits a weld with self-lifting slag.

TYPICAL APPLICATIONS:

Track links, rollers and sprockets, ropeway pulleys, trunion wearing plates, gears, shafts and general reclamation of all worn out carbon steel parts requiring subsequent matching. Other applications are pump housing, railends (medium Mn steel), forging dies, wheels, axles, couplings.

Also suitable for use as a supporting buffer between a top layer of harder weld metal and a soft mild steel base.

Recommended for hardfacing components such as machine parts, which must be easily machinable after hardfacing.

HARDNESS: 24 – 27 HRC

WELDING CURRENT: DC +/-, AC 70

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amp)	Net Wt. of Electrodes in a Carton (Kg)	Net Wt. of Electrodes in a Case (Kg)
3.15	450	90-120	4.5	18.0
4.00	450	130-170	5.0	20.0
5.00	450	155-200	5.0	20.0