

PRODUCT DATA SHEET

Afrox 300

Afrox 300 is a basic coated, AC/DC all-position electrode depositing a tough chromium alloy weld metal with a hardness of 250-300 HV (up to 30 HRc). The weld metal may be hardened to above 480 HV (48 HRc) by heating to 900°C and quenching in oil. The weld deposit is capable of withstanding moderate rolling loads, mild abrasion and frictional loading with good resistance to impact.

Applications

Afrox 300 is suitable for rebuilding worn steel or low alloy machine parts, which require machining after welding. It can also be used as a buffer layer between base material and harder overlays. Typical components to be welded with this electrode include shafts, mine car wheels, track links, dragline chains, worn rail ends, tractor rails, drive sprockets, etc. Afrox 300 may be multi-layered.

Classifications

DIN	8555	EI-UM-300-P
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Typical Chemical Analysis (All weld metal)

% Carbon	0,05 - 0,1	% Chromium	3,0 - 3,5
% Manganese	0,35 - 0,9	% Molybdenum	0,1 max
% Silicon	0,7 max		

Typical Hardness

HRc	26 - 31
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Packing Data

(DC+ AC 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
3,15	350	110 - 145	4,0	W075603
4,0	350	140 - 180	4,0	W075604
5,0	450	180 - 240	6,0	W075605

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