

# PRODUCT DATA SHEET

## Afrox 650A

Afrox 650A is a basic coated AC/DC all-position electrode depositing a weld metal containing chromium, molybdenum and vanadium. The weld metal which has an approximate hardness of 550-650 HV (53-58 HRc) is grindable only and has good resistance to abrasion with moderate to high impact resistance. Due to its high alloy content, the deposited weld metal has excellent hardness to 500°C.

### Applications

Afrox 650A deposits a martensitic steel weld metal which is suitable for use on a wide variety of tool and metal-to-metal applications such as guillotine blades, punches, dies, pneumatic drills, chisels, axes, ripper teeth and wood chipper anvils.

### Classifications

DIN	8555	E6-UM-55-GS
-----	------	-------------

### Typical Chemical Analysis (All weld metal)

% Carbon	0,45 - 0,65	% Chromium	5,5 - 7,5
% Manganese	0,5 - 1,25	% Molybdenum	4,5 - 6,5
% Silicon	0,1 - 0,5	% Vanadium	0,5 - 0,1

### Typical Hardness

HRc	53 - 58
-----	---------

### Packing Data

(AC DC+ 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
3,15	350	80 - 120	4,0	W075623
4,0	350	120 - 160	4,0	W075624

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02  
E-mail: [customer.service@afrox.linde.com](mailto:customer.service@afrox.linde.com) Website: [www.afrox.com](http://www.afrox.com)

