



NOVA™

TECHNICAL INFORMATION

NH 22 Hardfacing Electrodes

A special wear rutile electrode, which has high strength and toughness, combined with good abrasion resistance. Provides machinable deposit. Suitable for tractor idler wheels, rollers and track links, also ideal for surfacing gears, mine rails, shovel pads, pin and clutches. Hardness : 30 - 35 H.R.C.

- Special features :**
- 1) For multi-layer build up.
 - 2) Impact resistance.
 - 3) High flexibility.
 - 4) Deposits still machineable.
 - 5) Can weld 3 layers without cracks.
 - 6) Low ampere but deep penetration.

TYPICAL ANALYSIS OF ALL-WELD METAL DEPOSIT

Element	<u>C</u>	<u>Si</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Cr</u>	<u>Mo</u>
Deposited Metal %	0.15	0.39	0.98	0.01	0.01	1.62	0.01

- Uses :**
- 1) Repairing heavy-duty industrial equipment parts.
 - 2) Re-building up worn parts caused by impact and light abrasion.
 - 3) Foundation layer (before using the harder electrodes).

- Ampere setting :**
- AC or DC+
- 3.2 mm 80 - 120 amp (for mild steel and carbon steel)
110 - 140 amp (for cast iron)
- 4.0 mm 120 - 160 amp

The data published are to our best knowledge the correct information. We reserve the right to alter the specifications at any time and without prior notice.