



# NOVA™

## TECHNICAL INFORMATION

### NH 55 Hardfacing Electrodes

Rutile type electrode designed for ease of application with excellent metallurgical properties, combining good slag control and minimum spatter with easy slag removal. Suitable for hardfacing component of earth moving and rock crushing equipment that is exposed to serious impact. Also good for heat and wear resistance.

- Special features** :
- 1) Smooth arcing on AC or DC machines and particularly suitable for surfacing with portable AC welding sets.
  - 2) Very good hardness 58-60 H.R.C.
  - 3) Can weld 2 layers without cracks.
  - 4) Can weld at any angle, flat, horizontal vertical, vertical-up and overhead.
  - 5) Excellent penetration.
  - 6) Air hardening, martensitic steel deposit resistant to hard particle abrasion

#### **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>	<u>V</u>
<b>Deposit Metal %</b>	<b>0.41</b>	<b>0.52</b>	<b>0.82</b>	<b>0.01</b>	<b>0.02</b>	<b>4.85</b>	<b>0.38</b>	<b>0.08</b>

- Uses** :
- 1) Palm oil crusher, hammer and extruder.
  - 2) Heavy equipment parts.
  - 3) Earth moving, rocks and stone crusher.
  - 4) Stirrer, blender, mixer for concrete.
  - 5) Kiln segment (cement factory).

- Ampere setting** :
- AC and DC +  
3.2 mm 100 - 130 amp  
4.0 mm 120 - 180 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.*