



NOVA™

TECHNICAL INFORMATION

NH 88 Hardfacing Electrodes

The weld deposit of NH 88 is a typical structure of martensite. It has self-hardening property. Suitable for hardfacing of bulldozer links, buckets edges, dipper teeth as well as for rebuilding heavy-duty equipment parts. Hardness : 54 - 58 H.R.C.

- Special features** :
- 1) Impact resistance.
 - 2) Deposit will harder when knocked.
 - 3) Slag can be easily removed.
 - 4) 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>	<u>W</u>
Deposited Metal %	0.52	0.62	0.72	0.02	0.01	6.08	0.54	0.01

- Uses** :
- 1) Screw conveyor repair (worm).
 - 2) Stone crusher.
 - 3) Heavy equipment component.
 - 4) Sugar factory.
 - 5) Flour and powder factory.

Ampere setting : AC and DC +
3.2 mm 100 - 120 amp
4.0 mm 120 - 160 amp



Bulldozer cylinder head (Komatsu) cracked at combustion chamber – repaired by NH 88 and NCI 20 using combustion welding (passed the leak detector test).

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.