

# PRODUCT DATA SHEET

## Afrox 452

Afrox 452 is a basic coated AC/DC all-position electrode depositing a weld containing chromium, nickel and molybdenum. The weld metal, which comprises metallic carbides in a martensitic matrix, has a hardness of 420-480 HV (43-48 HRc). The weld metal provides good resistance to abrasion and impact under rolling and to impact loads in wet and dry conditions.

### Applications

This versatile electrode is suitable for use in applications where frictional loads and metal-to-metal wear conditions occur. The weld metal is extremely resistant to breakout or spalling, which makes it eminently suitable to use on permanent way crossings, rail ends, excavator bucket lips, tractor drive sprockets and track links, crane drive wheels, etc. The deposit, which is machinable with carbide-tipped tools, is also suitable for use as a low cost buffer layer for the deposition of high alloy wear resistant deposits.

### Classifications

DIN	8555	EI-UM-45-GP
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### Typical Chemical Analysis (All weld metal)

% Carbon	0,17 - 0,25	% Chromium	2,5 - 3,5
% Manganese	0,8 - 1,4	% Nickel	2,0 - 2,5
% Silicon	0,3 - 0,9	% Molybdenum	0,65 - 0,95

### Typical Hardness

HRc	43 - 48
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### Packing Data

(AC DC+ 70 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
4,0	350	110 - 170	5,0	W075674
5,0	450	170 - 270	6,0	W075675

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