




MANGALAM®

H.F. Electrodes - 650 R

Tough And Durable Hardfacing Solution

MANGALAM HF 650 is a rutile-coated electrode designed to provide a non-machinable deposit with a hardness of 650 VPN. Ideal for applications exposed to severe abrasion and moderate impact, this electrode ensures high wear resistance and can be finished by grinding. Perfect for industries requiring high-performance welding solutions.


Engineered For Extreme Wear Resistance



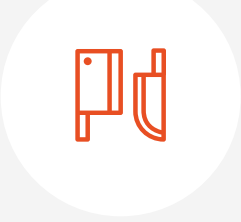
Crusher Jaws




Bucket Teeth




Pulveriser Hammers




Cane Cutting Knives And Hammers



Cement Mill Components



Crusher Hammers, Plough Shares, Oil Expellers, Etc.



Hot & Cold Punching Dies

Packing Data

SWG Size	Size (Mm)	Electrodes/Packet	Electrodes/Carton	Current (Amps)
12	2.50 X 350	225	900	70 - 90
10	3.15 x 450	130	520	100 - 140
8	4.00 x 450	85	340	140 - 180
6	5.00 x 450	50	200	180 - 220


Chemical Composition Of Weld Metal (%)

Element	Composition (%)
Carbon (C)	0.40 - 0.65
Manganese (Mn)	0.20 - 0.70
Silicon (Si)	0.20 - 0.70
Chromium (Cr)	5.50 - 7.00

Mechanical Properties Of All Weld Metal

Property	Value
Hardness	650 BHN Min (after third layer)

Current Conditions



Operates on **AC** current.



Operates on **DC** current.