

spark BELL 550

WELDING ELECTRODES

Air-hardening machineable weld deposit for resistance against abrasive wear with moderate impact at elevated temperature

Spark Bell 550 is a heavy coated hard-facing electrode which offers a high resistance to severe abrasion and impact at an elevated temperature. The weld deposit retains its hardness up to 550°C. The electrode deposits contain Nickel and Molybdenum rich weld metals.

Special feature:

Spark Bell is ideally suited for repairing of blast furnace bell and similar parts.

Applications:

- Blast Furnace Bells and Hoppers
- Foundry parts
- Tong Pins, Cutting Knives, Valve Seat & Rolling Mill guides
- Hot Shears, Crusher Jaws
- In steel plants for equipment used at elevated temperatures

Welding Parameters: Current: AC 70, DC +/-

Size (mm x mm)	Current (Amps)
3.15 x 450	90-120
4.00 x 450	115-175
5.00 x 450	160-225

Hardness

500 Hv (49 Rc) at 400°C
475 Hv (47 Rc) at 450°C
460 Hv (46 Rc) at 500°C
415 Hv (42 Rc) at 560°C

