



EAGLE 635

Hardfacing for moderate impact and severe abrasion.

APPLICATIONS

Used for hardfacing bucket teeth, buckets, bucket lips, grapples, mixer paddles, ripper teeth, screw conveyors, compactors, mill hammers, sides of scrapers and mining equipment.

PROCEDURE

AC or DC reverse polarity (+). Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use lowest effective amperage while maintaining a medium arc length making either stringer beads or weave beads with a maximum of two layers of weld deposit.

GENERAL CHARACTERISTICS

The **EAGLE 635** is a high chromium carbide electrode containing alloys for good resistance to severe abrasion, moderate impact and will weld excellent out of position.

TECHNICAL DATA

Tip Color:	Lime Green					
Hardness: (RC)	Approximate 60 - 63					
Current:	AC - DC Reverse (+)					
Sizes: (IN)		3/32	1/8	5/32	3/16	1/4
(MM)		2.50	3.25	4.00	5.00	6.00
Amperage:		45 - 70	80 - 125	130 - 190	200 - 240	250 - 300

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