



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, mill hammers, sides of scrapers and mining equipment.

PROCEDURE

Use 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 high chromium carbide electrode containing alloys for good resistance to severe abrasion, moderate impact and will weld excellent out of position.

TECHNICAL DATA

Tip Colour: Lime Green
Hardness: (RC) Approx. 60 - 63

WELDING PARAMETERS

| | | | | | | |
|---------------|-------------------------------|--------|---------|---------|---------|--|
| Current: | AC or DC Reverse [+] Polarity | | | | | |
| Sizes: Inches | 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 | |



≡ HIGH QUALITY WELDING PRODUCTS ≡

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