

S-711

AS/NZS 2576: 2360-A4

TYPE : Basic

Applications

Typical applications include: Mills to crush clinker in cement industry, screws of crushing grains in oil industry.

Characteristics on Usage

S-711 is highly resistant to abrasion without impacts. S-711 is an electrode depositing wild metal of carbide/austenite structure which is harder than that of S-700B.B.

- This electrode deposits weld metal of austenite structure containing Cr-Carbide.
- Machining is not possible.

Notes on Usage

- 1) Preheat at 150°C or more
- 2) Weave during welding, with the width of approx. 50mm.
- 3) Avoid excessive dilution.
- 4) Dry the electrodes at 350~400°C for 60 minutes before use.

Surfacing Position



D/H Hor.

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Cr |
|------|------|------|-------|-------|-------|
| 3.47 | 0.90 | 1.11 | 0.018 | 0.014 | 33.87 |

Typical Mechanical Properties of All-Weld Metal

| Preheat & Interpass Temp. °C | Hardness (HB) |
|------------------------------|---------------|
| ≥150 | 610 |

Approval

I Packing

Packet 5 kg
Carton 5 kg x 4 : 20 kg

Sizes Available and Recommended Currents (Amp.)

| Size mm (in) | 3.2 | 4.0 | 5.0 |
|---------------|---------|---------|---------|
| Length mm(in) | 400 | 400 | 400 |
| Flat: | 110~160 | 160~200 | 200~260 |

| Diam. | 5kg Pack |
|-------|-----------|
| 3.2mm | HKS-71132 |
| 4.0mm | HKS-71140 |

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