

# **Addifix 780**

**HARDEST, MOST ABRASION RESISTANT  
FERROUS BASE HARD FACING ELECTRODE  
AVAILABLE (AC/DC+)**

High concentration of Carbon, Chromium, Molybdenum, Columbium, Tungsten and Vanadium produce very large amount of extremely hard, complex carbides.

Hardness:	65-67 ROCKWELL "C"
Diameter:	1/8    5/32    3/16
Amperage:	150    190    250

- 
- Large concentrations of carbide forming elements produce ultra hard carbides in a tough Austenitic matrix.
  - Resists intense abrasion with moderate impact.
  - Large Columbium addition causes the deposit to retain extreme hardness with decent toughness.
  - Even at 1100°F the highly alloyed deposit is still 40 Rockwell "C" hardness.
  - Maximum single pass hardness produced by a ferrous base hard facing.
  - Approaches Tungsten Carbide in wear resistance.
  - Runs flat and inclined upward.
  - Limit hard facing to two layers maximum, and for additional build-up cushioning use ADDIFIX 770.
  - Totally non machinable and may only be ground with great difficulty.

**Typical Industrial Applications:** Blast furnace charging systems parts, iron ore sinter plants, coke oven pusher parts, coal augers, toothed ore disintegrating rolls, wear bars, wear plates, sand pumps, cement pumps, foundry wear parts and scraper bars in the zinc industry.