

CIGWELD

AN **ESAB** BRAND

WeldSkill

HARDA

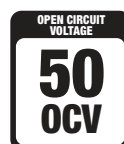
“ WeldSkill Electrode
handy-packs for all of
your smaller projects ”

FEATURES

- Basic Type Manual Arc Welding Electrode
- Resistant to Hard Particle Abrasion and Moderate Impact Loading
- Air Hardening, Crack Free, Martensitic Steel Deposit - 650 HV30



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WELDSKILL HARDA

WELDSKILL HARDA is a basic electrode for the hard surfacing of steel components subjected to wet or dry hard particle abrasion and low to moderate impact loading.

The air hardening, low alloy steel deposit of WELDSKILL HARDA remains crack free on most steels under normal welding conditions and is therefore recommended for hard surfacing components subject to flexing during service.

The basic flux coating gives excellent resistance to rust, mill scale, dirt and oil on the surface being hardfaced. Typical applications include the surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

CLASSIFICATIONS

AS/NZS 2576: 1855-A4.

W.T.I.A. Tech Note 4: 1855-A4.

SPECIFICATIONS

Diameter (mm)	Current Range (amps)	
	Min	Max
3.2	105	135

TYPICAL WELD DEPOSIT HARDNESS

	HR _C	HV ₃₀
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	57	640

TYPICAL ALL WELD METAL ANALYSIS

C: 0.58% Mn: 1.1% Si: 0.6% Cr: 5.3% Mo: 0.25%

FINISHING RECOMMENDATIONS

Not Machinable / Grinding only

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ORDERING INFO

Part No.	Size	Pack Size	Carton
WEH0232	3.2mm	10 rods	20 x 10 rods
WEH1032	3.2mm	1kg	12kg - 12 x 1kg



Downhand & Horizontal surfacing applications:

3.2mm and 4.0mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.



CIGWELD Pty Ltd An ESAB Brand 71 Gower Street, Preston VIC 3072 Australia
Customer Care: Tel: 1300 654 674, Fax: 03 9474 7391, Email: enquiries@cigweld.com.au
International Enquiries: Tel: +61 3 9474 7508 Fax: +61 3 9474 7488



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In the interest of continuous improvements, CIGWELD Pty Ltd ABN 56 007 226 815 (An ESAB Brand) reserves the right to change specifications or design on any of its products without prior notice.

WE RECOMMEND GENUINE CIGWELD PRODUCTS

BIGGEST RANGE, BEST QUALITY & GUARANTEED PERFORMANCE

