



MASTERWELD

Masterweld 474 HR

■ Description & Applications :

High recovery chrome / cobalt / iron based electrode designed to combat all four elements of wear, i.e. heat, impact, corrosion and abrasion, but with emphasis on impact properties. The addition of molybdenum refines the grain structure and produces good hot hardness. Excellent for rebuilding corners with minimum base metal dilution. Has ability to overlay extensive areas without cracking. Will retain hardness at high temperatures. The welds are machinable and will work harden under impact. Designed initially as a forging material for either repairs or sinking. Recommended for use in the iron and steel industries. Suitable for use on shear blades and dies. Due its excellent impact properties and refined grain structure this electrode is ideally suited to clipping tools and forging punches.

■ Typical All Weld Metal Chemical Analysis % :

C	Si	Cr	Ni	Fe	Mo	Co
0.11	1.12	22.01	1.32	14.34	4.78	56.32

■ Typical All Weld Metal Deposit Hardness

25-30 RC as deposited (will work harden up to 50 RC under impact)

■ Current :

AC/DC+

■ Sizes Available and Recommended Amperages :

2.5mm	3.6mm	4.0mm	5.0mm	6.4mm
70-90	90-115	110-150	140-190	220-275

■ Storage :

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.

