



Welding Products

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9009

Data Sheet

SUPERIOR HIGH ALLOY ELECTRODE WITH EXCELLENT ABRASION AND GOOD IMPACT RESISTANCE.

HIGH DEPOSITION RATE.

AC OR DC REVERSE POLARITY (ELECTRODE+)

GENERAL CHARACTERISTICS:

9009 is designed for use on carbon and low alloy steels, manganese steels, and cast iron. Deposits take a high polish, which contributes to high frictional and abrasion wear qualities, especially small particle abrasion. Excellent on applications that need impact as well as abrasion resistance. Provides optimum resistance to this combination. Deposits well out of position.

APPLICATIONS:

9009 is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1,000°F. Especially designed for crusher applications. Used heavily in construction, mining, brick and clay industries on parts such as crusher rolls, jaw crushers, bucket teeth, edges, hammers, mill hammers, conveyor screws, etc.

TECHNICAL DATA:

Hardness				RC 57-61
Current.....				AC or DC reverse polarity (electrode+)
Amperage	80-125	100-160	125-190	
(in)	1/8"	5/32"	3/16"	
(mm)	3.25	4.0	5.0	

PROCEDURE:

Remove any fatigued or unsound metal with Blow Out. According to the thickness of deposit and type of base metal, a padding of E/O-8600 or Perfect Pass CBU might be considered. On cast iron, a base of Perfect Pass NA111 is recommended. Deposits can be applied as stringer beads; however, weave passes are recommended for maximum deposition rate. Prevent excessive heat build-up. Allow parts to cool slowly.