



**Welding Products**

**Distributed by Agri Tool & Supply**

**CARB  
9109**

**Data Sheet**

# **ULTIMATE HARD-FACING ELECTRODE FOR MEDIUM IMPACT AND HIGH ABRASION**

AC OR DC REVERSE POLARITY (ELECTRODE+)

## **GENERAL CHARACTERISTICS:**

High deposition rate electrode that produces smooth beads and in most cases the slag comes off all by itself. The arc is easily controlled and prevents excessive dilution with the base metal. The high chromium content of these electrodes makes the weld deposits maintain their resistance even at elevated temperatures.

## **APPLICATIONS:**

Parts subjected to severe abrasion as well as light impact such as equipment for processing soil, rock, coal cement, grinding plates, dredger teeth, conveyor screws, coal augers, agitators, earth augers and scrapers. Also for surfaces that must resist abrasion combined with scaling such as open-hearth tools, grates, conveying chains in annealing furnaces and manipulators.

## **TECHNICAL DATA:**

Hardness as Welded ..... up to 56-60 RC  
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 foreign material and unsound metal from surface to be welded. For best results and long service life an elastic cushion layer should be applied to the part before surfacing with this electrode. Use e/0-8600 or Perfect Pass CBU for a cushion layer on carbon steels and manganese steels; on cast iron use NA 111. When making the final surface with Perfect Pass Chrome Carb 9109 keep electrode vertical to the work piece and maintain a short arc. Deposits must be kept thin, never more than two layers thick. To prevent excessive local heat build-up in the part, alternate welding area. Allow part to cool slowly.