

ESSEN® CCR9009

AC/ DC +

Specially formulated electrode for surfacing of hammers

PROPERTIES

For tough, wear-resistant overlays on hammers. Weld deposits have fine homogenous distribution of Titanium carbide in a martensitic matrix. Used as a buffer layer to overlay with ESSEN CCR 65

MECHANICAL PROPERTIES

HARDNESS : 3200 HV (Titanium Carbide)

HARDNESS : 64 to 68 HRc (Deposited Metal)

APPLICATIONS

For initial overlay on heavily worn hammers prior to surfacing/buid-up with intermediate and top up electrodes, viz; ESSEN CCR65, ESSEN CCR7007.Excellent for rebuilding of worn hammers in Sugar, Cement, Mining, Thermal Power Generation industries.

WELDING PROCEDURE

Clean weld area. Remove old welds; fatigued materials on worn hammers. Overlay with two layers of ESSEN 9009. Chip slag between passes. Maintain interpass temperature.

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	120 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps

PACKING	
3.15 mm x 350 mm 5 kg	15 pcs/kg (Approx.)
4.00 mm x 350 mm 5kg	11 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

ESSEN® PRODUCTS ARE MANUFACTURED AND SUPPLIED
ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
TM REGISTERED IN INDIA BY: M/S. ASUGAR ENGINEERS PVT. LTD.
PUNE, VIDE REGD. T.M. NO. 543993 B.

'Sai maa', Post : Kadam Wak Wasti via Loni Kalbhori, Post P. B. No.1, Tal.: Haveli,
Dist.: Pune 412201, INDIA TEL: +91 -20 -65781493, 26911175 26911029 FAX: +91-20-26911030
Email: asugar@pn3.vsnl.net.in / essenelectrode@vsnl.net.in
Website: essenelectrode.com