

XL – BMC

General Characteristics

XL-BMC is a basic coated high recovery special electrode for joining and surfacing manganese steels. Also used for welding armour plates and generally poorly weldable steels. Also suitable for sub-layer before hard surfacing. Also suitable for surfacing layers requiring high impact and eventually cavitation resistance.

Applications

Railway crossings, dredge pumps, hydraulic press pistons, crusher parts undergoing high impact by abrasive minerals.



Mechanical Properties

Hardness of weld as deposit: 200-250 HB
Work hardening: 450-550 HB.

Recommended Current

Diameter (mm) (in)		Length (mm) (in)		Current (Amps)
3.15	1/8	350	14	100-140
4.00	5/32	350	14	130-190
5.00	3/16	350	14	200-250

Packing

5 Kgs.

X'tralife

X'tralife to your wear prone components



**Wearresist
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An ISO 9001 : 2008 Company

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