

# Technical Data Sheet

## 711 Flux-Coated Electrode

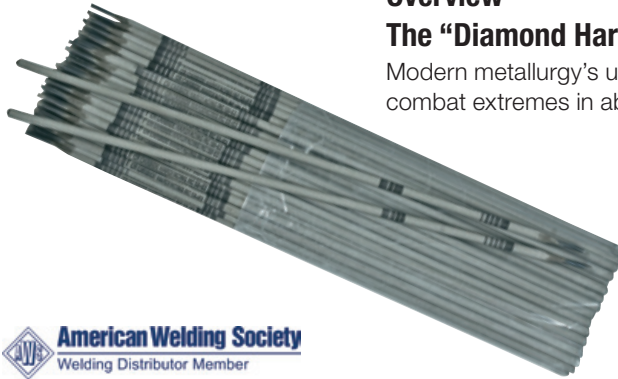


**Cronatron™**  
A LAWSON BRAND

### Overview

#### The “Diamond Hard” Alloy Electrode

Modern metallurgy’s ultimate answer to the need for a super-hard overlay to combat extremes in abrasion and impact.



### Features/Benefits

- Fastest deposition rate of any hardsurfacing electrode
- Self-lubrication factor minimizes most severe abrasion
- High resistance to impact
- Developed for mining and construction equipment
- Smooth surface deposits retain hardness at high temperatures
- Finished surface can be produced by grinding

### Applications

- Grader blades and clamshell bucket lips
- Trencher teeth and backhoe bucket teeth
- Augers and crusher jaws
- Feeder screws
- Pump impellers
- Dozer end bits
- Sizing screens
- Asphalt-mixer paddles
- Road-ripper teeth
- Sand and stone conveyors

### Method of Application

AC or DC reverse polarity

### Identification

Printed gray electrode

### Directions for Use

Area to be surfaced should be chamfered or ground to remove old welds and scale. Preheating necessary only on cast iron or alloy steel. Using AC or DC reverse polarity; hold electrode almost perpendicular and use weave technique. Where necessary, up to four layers can be used. Hesitate over final crater and backwhip. Do not remove slag until cool.

### Technical Specifications

Hardness: Rc 58 to Rc 63

### Technical Tips

The fastest and easiest way to remove old welds or to chamfer edges in preparation for application of 711 Flux-Coated Electrode is to use Cronacut Eagle™ 1100. This can reduce preparation time 80%.

