

# Technical Data Sheet

## 777 Electrode The “Shock Absorber” Alloy



**Cronatron™**  
A LAWSON BRAND



### Overview

Exclusively formulated for applications where severe impact and extreme shock conditions prevail.



### Features/Benefits

- Outperforms standard hardfacing alloys in shock and impact situations 10-to-1
- Work-hardens under any condition to become tougher, stronger and harder
- Formulated with special alloys that prevent brittleness and eliminate cracking
- Can be cut with oxyacetylene torch

### Applications

- Joining manganese or carbon steel
- Buildups and overlays on all applications where impact and shock exists
- Joining bucket teeth and lips to buckets
- Crushers
- Hammer mills
- Tampers and jackhammers
- Railroad frogs

### Method of Application

AC or DC reverse polarity

### Identification

Printed green coating

### Directions for Use

AC or DC reverse polarity. Weld surface should be chamfered, using Cronacut Eagle™ 1100 or by grinding. Remove all grease, paint scale or previously applied weld deposits that have become cracked or embrittled. Avoid localized overheating on manganese steel.

### Technical Specifications

Tensile Strength: 115,000 PSI (793 MPa)  
Hardness: Up to Rc 54, Work hardened

