ROAD MACHINERY & SUPPLIES CO.

SUPER-HARD CHROME

ATTACHMENT RECOMMENDATIONS

All non-stock sizes must first be cut with CNC plasma, then follow the procedures listed below for the method that best fits your application.

Studding

- This is the best method for environments with significant impact and vibration
- Stud should always be installed to the non-chrome side
- Stud and base material should be made from compatible materials
- Stud diameter must not exceed the thickness of the base plate material

Welding

- Weld only to the non-plated side
- Keep the base material under 250° C. A wet rag can be place on the plate surface to draw heat from the plate, keeping the plate at the cooler temperature.
- Tack welding is recommended for attaching to a base surface or structural steel surface. Remember to keep the tack spaced out in even intervals, below the chrome surface.
- MIG welding is the latest disruptive method for tack welding. If stick welds are used, we recommend a 7018, low hydrogen rod.

Bolting

- Hard chrome surface can be drilled and if necessary, countersunk. We recommend that TriTec Steel prepare the base material with the countersunk holes prior to hard plating. This insures the chrome surface will remain continuous, avoiding the possibility that a premature wear spot develops around the hole.
- Bolt heads can be hard-plated as well. This is highly recommended for continuously flowing surfaces such as feeder liners and chutes.

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