

# SUNALLOY 017

Electrode for tough and wear - resistant surfacing alloy deposit



## DESCRIPTION

SUNALLOY 017 is a lime-base coated electrode for hard facing on structural and machine parts which are subject to wear and impact load. Even thicker layers are tight and free from cracks. The welding material has good machining properties and can be flame hardened additionally. Considerable increase inwardness by means of heat treating is not achieved.

## ALLOY BASIS

Cr, Mn

## PROPERTIES

Basic, all position electrode. The deposit is particularly resistant to impact and friction. Thick surfacing without intermediate layers possible.

## APPLICATIONS

Rail Crossing Points, Couplings, Shafts Gear Wheels, Machine Parts Earthmoving and Agricultural Machinery. SUNALLOY 017 is ideally suited for construction & mining machinery parts like track sprockets, rollers, concrete mixer blades, pump shafts and conveyor screws. Surfacing of parts subject to wear or impact: rims, carbon-alloyed rails, dies, striking tools, rolling surfaces, sliding surfaces subject to heavy wear, stampers, etc. The right choice for providing buffer layers where impact and abrasion occur together.

## PROCEDURE

Prepare weld groove using SUNALLOY 109, grind surfaces to remove hard spots. Clean weld area thoroughly. Ensure electrodes are completely dry. Weld using a "short" arc procedure with the electrode almost vertical. A "touch" technique can be used for horizontal welding. Weaving should be limited to about 5 times electrode size. De-slag completely before over-welding.

## MECHANICAL PROPERTIES

Hardness of the weld metal (as deposited): 275 - 325 HB

## TECHNICAL DATA & WELDING PARAMETERS

Size (diameter)/length (mm)	: 3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 100 - 130	140 - 160	170 - 190
Current	: AC/DC (+)		