

SUNALLOY 117

Highly wear resistant, tough surfacing electrode



DESCRIPTION

A modified SUNALLOY 117 electrode for hard facings with high resistance to wear. Suitable for machine parts which are subject to high abrasive wear as well as impact load. Deposits are normally crack free.

ALLOY BASIS

Fe, Cr, Mo

PROPERTIES

Basic electrode with excellent welding characteristics. Economical for making hard overlays in all positions. Gives regular beads. The deposit is hard, tough and free from porosities.

APPLICATIONS

Earthmoving undercarriage parts, axles, crane wheels rims, clutches, slides and guidways, cams, shafts couplings rail crossing points gear wheels. To surface parts subject to heavy abrasive wear and mild impact: digger teeth, drills, conveyor screws, cutting and forming tools, punches, hot-work dies, shear blades, crusher hammers, conveyor buckets, conveyor parts, plough-shares, cultivators, pulverisers, skids, mixers, oil expeller worms, etc. Also manganese steel parts subject to high abrasion.

TECHNICAL DATA

Hardness of pure deposit : 56 - 58 HRC

TECHNICAL DATA & WELDING PARAMETERS

Size (diameter)/length (mm)	: 2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 70 - 90	90 - 140	140 - 185	180 - 230
Current	: AC/DC (+)			