

## DESCRIPTION

Lime coated electrode for hard facing on machine parts which are subject to high friction wear. It is also suitable for repairs on damaged cold cutting tools and the protective lining with surfacing on austenitic manganese steel. In spite of its hardness, the welding material is tough and not susceptible to impact loads. In this natural state the workability of the weld is limited to grinding.

## ALLOY BASIS

C, Fe, Mn, Cr

## PROPERTIES

Crushing Heads and Rings, Cams and Rammers, Rollers, Conveyor and Earth boring Screws, Impact Strips, Mixer Parts, Dredger Teeth, Earth and Mineral moving equipments.

## APPLICATIONS

Prepare weld groove using SUNALLOY-109, grind surfaces to remove hard spots, clean weld area thoroughly. Ensure electrodes are completely dry. Preheat to 200°/300° C is advisable, particularly on heavier sections. 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 where deposits of more than 3 or 4 layers are required, buffer layers using SUNALLOY- 017 or SUNALLOY- 801 depending on base metal.

## MECHANICAL PROPERTIES

Hardness of the weld metal (as deposited) : 57 - 61 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	100 - 120	130 - 160	170 - 190
Current	: AC/DC (+)			