

SUNALLOY 417 S

Electrode for medium-tensile, ductile steel welds



DESCRIPTION

Basic coated high recovery special electrode. Joining and surfacing manganese steels. Welding armour plates and generally poorly weldable steels. Sub-layer before hard surfacing. Surfacing requiring high impact and eventually cavitation resistance.

ALLOY BASIS

Fe, Mn, Cr, C

PROPERTIES

Work hardening type electrode with very high deposition rate. Extremely ductile and hence ideal for intricate and hardened manganese steel parts. Has very fast work hardening tendency, high abrasion resistance and resistance to deformation and cracking.

APPLICATIONS

Railway crossings, dredge pumps, hydraulic press pistons, crusher parts undergoing high impact by soft minerals. For all position welding of 14% Mn steels, armour steels, carbon steels. Also for surfacing of such steels. Ideal as under layers before surfacing on 14% Mn steels, hard or unidentified steels. Very thick build-ups possible without cracking.

TECHNICAL DATA

Tensile strength	:	80 - 85 kgf/mm ²
Elongation	:	30 - 33%
Hardness as welded	:	17 - 20 HRC
After hardening	:	42 - 50 HRC
Deposition rate (metal recovery)	:	140%

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 - 180	180 - 230
Current	:	AC/DC (+)			