

DESCRIPTION

Resistant to heavy loads produced during crushing of canes. Smooth and Stable arc, even in positional welding, provides faster build-up due to high deposition rate. Excellent deposition with an aggressive “spray-type” arc, Permits its use even while the rolls are in operation; imparts better grip to canes being crushed, thus increasing the efficiency and productivity of the Sugar Mills.

ALLOY BASIS

Fe, Cr, C

APPLICATIONS

Primarily for “Spot-Arc” building / roughening the chilled cast iron rolls in the Sugar Mills. Also for reclamation of Sand Slides, Scrapers, Screw Flights, Mixing Paddles, etc.

TECHNICAL DATA

Hardness : 560 - 640 BHN

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	120 - 140	140 - 160
Current	: AC/DC (+)			