

SUNHARD 250

Hard Facing Electrode

CHARACTERISTICS

SUNHARD 250 is a medium, heavy coated rutile type electrode manufactured for hardfacing of carbon steel and low alloy steels where hardness of 250 Brinell is required. Very stable arc, easily removable slag and smooth weld bead.

APPLICATIONS

Ideal for welding of tram tyres, Gears, Pinion teeth, Couplings, Sugarcane crushers, Hammers and spindle machines etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium	Molybdenum
0.16	0.42	0.27	0.71	1.05

HARDNESS (Typical) : On second layer 260 BHN

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
3.15	350/450	100-120	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-220	5 Kg	20 Kg

RECOMMENDATIONS:

Use short arc and lower current within the range. Avoid weaving of electrode to obtain best results. Electrodes should be re-dried at 100°C for 30 minutes. If the base material has the carbon content of more than 0.25%, a buffer layer using a low hydrogen electrode is recommended.