

SUNHARD 550

Hard Facing Electrode

CHARACTERISTICS

SUNHARD 550 is a medium, heavy coated rutile type air hardening electrode for hardfacing application on mild steel, carbon steel and low alloy steel where 550 BHN is required. The welds are non machinable and only be ground. Slag is easily detachable.

APPLICATIONS

Typical application includes welding of metal cutting and forming tool, Shears and croppers, oil expellers, cane cutting knives, Conveyor bucket and mixed blades etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium	Molybdenum	Vanadium
0.62	0.37	0.43	6.58	0.45	0.52

HARDNESS (Typical) : 560 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	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 stringer bead technique and avoid high current. Short arc ensures proper alloy transfer to weld deposit. Ensure the electrodes are dry, moist electrodes should be re-dried at 125°C for one hour.