

# SUNHARD 600 LH

Hard Facing Electrode

## CHARACTERISTICS

SUNHARD 600 LH is a heavy coated air hardening type electrode specially designed for hardfacing and building of worn out machine parts which are subjected to extremely severe service conditions involving a combination of impact and abrasion. The weld deposit is extremely hard, sound and non machinable.

## APPLICATIONS

Typical applications include bamboo chipper knives, Cane cutting knives, Punches, dies, Drilling bits, Shears and surfacing re building of mill hammers for pulverizing coat. Also find applications in Mill hammers, Rock drills, Dipper teeth, Shovel Latch Bars, Dump Truck Bodies, Car Couplers, Drive sprockets, Drive shafts etc.

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium	Molybdenum	Vanadium
0.063	0.64	0.66	7.39	0.92	0.52

**HARDNESS (Typical) :** On second layer 582 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	350/450	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.