

SUNHARD V

Hard Facing Electrode

CHARACTERISTICS

SUNHARD V is a medium heavy coated basic type graphite electrode for hardfacing and builds up of worn out machine parts & components. Weld beads are flat & smooth. Slag is easily detachable. The weld metal is alloyed cast iron which is hard & extremely resistant to abrasion and metal metal wear.

APPLICATIONS

Specially suited for rebuilding of oil expeller worms & re-building worn out parts to extend their life. Some of the typical applications include Oil Expeller Worm, scrapers blades, screw conveyor, Muller tyres, plough shares, cement die rings, bucket teeth, dipper teeth, concrete mixer blades etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Chromium
2.52	1.25	0.36	3.62

HARDNESS (Typical) : On second layer 540 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:

To get the optimum results re-dry the electrodes at 150°C. Use stringer bead technique to control the rate of cooling. Use short arc and lower currents of the recommended range. Use suitable buffer layer and preheat depending on base material composition and thickness.