

WELDARC

Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

WELDARC SV1

FEATURES

- Excellent Abrasion Resistance under Low to Moderate Impact.
- Particularly suitable for Wear Resistant Overlays on Austenitic Manganese steels.
- Can also be used on Carbon & Alloy steel.
- Weld-metal recovery is as high as 80 to 85 %.
- High Deposition rate, No slag removal, Non-hygroscopic coating and No pre-drying.
- Longer shelf-life

TYPICAL APPLICATIONS: Bucket lips & teeth, primary coal crushing jaws & hammers, quarry screen plates, blow bar, mantles & liners, gyratory and cone crusher parts, etc.

ALLOY BASIS C, Cr.

STRUCTURE. Weld-metal contains large quantities of Chromium Carbides in tough Matrix of Austenite.

HARDNESS Single Layer 52to 56 Rc.
Two Layers 58 to 61 Rc.

RECOMMENDED CURRENT DC (+) Preferred / AC 70 OCV

| Size (mm) | Amps |
|-------------|------------|
| 6.30 x 450 | 75 to130 |
| 8.00 x 450 | 110 to160 |
| 10.00 x 450 | 130 to 180 |

IDENTIFICATION Tip Color – MINT GREEN

PACKING DATA

Plastic Carton : 5 kgs.
Card board Case : 30 Kgs.
Pallet : 900 Kgs

Surface Relief-Checks in weld-metal are normal and infact, desirable. These checks prevent stress build-up because of high hardness and high-alloy contents.

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