

WELDARC

Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

WELDARC SV 108

FEATURES

- Excellent Resistance to Extreme Abrasion under Low Impact.
- Ultra-fine tool- steel matrix with Tungsten Carbides and Iron-Chromium-Carbides.
- Weld-Metal recovery is as high as 80 to 85 %.
- High Deposition rate, No slag removal, Non-hygroscopic coating, No pre-drying.
- Longer shelf-life

Typical APPLICATIONS: Muller blades, Oil-drill collars, pan scrappers, concrete mixtures, conveyor screws sand-Muller blades / arms etc..

ALLOY BASIS C, Cr, W

STRUCTURE Tungsten Carbides and Fe-Cr-W Carbides in Chromium Rich matrix.

HARDNESS Two Layers 64 to 67 Rc
Tungsten Carbide – 1800 VPN

RECOMMENDED CURRENT DC (+) Preferred / AC 70 OCV

Size (mm)	Amps
6.30 x 450	75 to130
8.00 x 450	110 to160

IDENTIFICATION Tip Color – BUS 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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