

# WELDARC

## Tubular Hardfacing Stick Electrodes for Sugarcane Fiberiser Hammers & Cane Cutting Knives.

All Position Welding including Vertical Down

## WELDARC SV120

### FEATURES

- Excellent Resistance to both coarse & fine Abrasion under Moderate to heavy impact.
- 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** Sugarcane Fiberiser / Shredded Hammers. & Cane Cutting Knives

**ALLOY BASIS** C, Cr, Mo, Ni, V

**STRUCTURE.** Weld-metal contains Complex Carbides of Chromium, Molybdenum and Vanadium in tough Austenitic matrix.

**HARDNESS** Two Layers: 57 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 – GOLDEN BROWN

**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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