

WELDARC

Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

WELDARC SV18

FEATURES

- Machinable Deposit.
- Excellent Resistance to Corrosion or Chemical attack accompanied with Abrasion / Erosion .
- 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 Valve seats, crusher parts employed in the chemical & mining industries.

ALLOY BASIS C, Cr, Ni, Mo,

STRUCTURE. Weld-metal is Chromium- Nickel alloy with appreciable quantities of Chromium Carbides in a tough Austenitic Matrix.

HARDNESS Single Layer: 48 to 52 Rc.
Two Layers: 52 to 56 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 – DEEP GREEN

PACKING DATA

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

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