

WELDARC

Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

WELDARC SV2

FEATURES

- Chrome Manganese Electrode having Excellent Work Hardening Properties.
- Resistance to Impact accompanied with Abrasion.
- General purpose joining, surfacing and buttering.
- Crack free thick deposit for rebuilding, reclamation of heavy parts made of Mn steel or Carbon 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: Railway points & crossings, crusher jaws, crusher hammers, blow bars, toothed crusher rolls, swing hammers, crusher mantles etc.

ALLOY BASIS C, Mn, Cr

STRUCTURE. Weld-metal is composed of Cr-rich Austenitic deposit

HARDNESS As welded : 25 to 30 Rc.
Work hardened upto :50 to 52 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 – PINK

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

Note : Weld-Metal being rich in Mn is sluggish in nature. Hence, Nominal weaving / Stringer bead is preferred.

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