

# WELDARC

## Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

## WELDARC SV4

### FEATURES

- Excellent Resistance to severe fine Abrasion under Low to Moderate Impact at both Ambient and elevated temperature upto 800 Deg. C.
- 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:** Sinter breakers, sinter fans, clinker wear parts, blast furnace bells & hoppers etc.

**ALLOY BASIS** C. Cr, Mo, Nb, W, V

**STRUCTURE.** Weld-metal contains Complex Carbides of Cr, Mo, Nb, W in tough Austenitic Matrix

**HARDNESS** Two Layers 62 to 65 Rc.

**RECOMMENDED CURRENT** DC (+) Preferred / AC 70 OCV

Size (mm)	Amps
6.30 x 450	75 to 130
8.00 x 450	110 to 160
10.00 x 450	130 to 180

**IDENTIFICATION** Tip Color – POST OFFICE RED

### 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.

## SHARADA WELDING (P) LTD.

Mukherjee Industrial Complex, Mahamayatala, Garia,  
Kolkata 700 084, INDIA

Ph. +91 33 2435 5451 / 8512, 3093 1431

Fax: +91 33 2840 0525 , +91 33 2827 1218, Tele Fax 91 33 2 464 5106

E-mail [weldarc@cal3.vsnl.net.in](mailto:weldarc@cal3.vsnl.net.in) / [shardawelding@vsnl.net](mailto:shardawelding@vsnl.net)

Website [www.sharadawelding.com](http://www.sharadawelding.com)