

# WELDARC

## Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

## WELDARC SV5

### FEATURES

- Excellent Resistance to Extreme Abrasion under Low 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:** Oil-drill collars, pan scrappers, concrete mixtures, conveyor screws sand-muller blades / arms etc.

**ALLOY BASIS** WC, Cr.

**STRUCTURE.** Weld-metal contains Fine Tungsten Carbides and Fe-Cr-W Carbides in Iron - Rich matrix.

**HARDNESS** Two Layers 64 to 68 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 – SKY BLUE

**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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