

# WELDARC

## Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

## WELDARC SV 50

### FEATURES

- Machinable Deposit.
- Good Abrasion Resistance under Heavy Impact.
- Particularly suitable for Hardfacing of Cast Iron.
- Can be used on Carbon & Alloy steel and also Manganese 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:** Shaft, conveyor screws, wire-drawing drums, wear-resistant build-up which requires machining.

**ALLOY BASIS** C, Cr.

**STRUCTURE.** Weld-metal contains appreciable quantities of Chromium Carbides in tough Matrix of Austenite.

**HARDNESS** Two Layers / Three Layers : 47 to 52 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 – OLIVE GREEN

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

### 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)