

WELDARC

Tubular Hardfacing Electrodes for Arcing of C.I Sugarcane Crusher Rolls.

Sugartrode SV80

FEATURES

- First time a breakthrough – a touch type Tubular Electrode for Arcing of Sugarcane Crushing Rolls in-situ and juice-on condition.
- Rough & Hard globular weld –metal deposition
- 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 Arcing of Sugarcane Crusher Rolls.

ALLOY BASIS C, Cr, Ni.

STRUCTURE. Weld-metal contains Chromium Carbides in tough Austenitic Matrix..

HARDNESS Two Layers: 58 to 61 Rc.

PROCEDURE

- Apply Sugartrode SV80 by keeping it inclined about 60 deg below the horizontal line and in the direction of the movement of the Roll.
- Deposit on the side walls of grooves maintaining the Sugartrode SV80 in contact with the Roll in operation at a speed of 4 – 8 RPM.
- All applications can also be directly on sugar impregnated surfaces of Roll.

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 – LIGHT ADMIRALITY GREY

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

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