

WELDARC

Tubular Hardfacing Stick Electrodes

All Position Welding including Vertical Down

WELDARC SV9

FEATURES

- Excellent Resistance to Heavy Impact and gets work hardened.
- Particularly suitable for rebuilding, reclamation of heavy parts made of carbon or 14% Mn - steel.
- High metal recovery 80 to 85 %.
- High Deposition rate, No slag removal, Non-hygroscopic coating, No pre-drying and Longer shelf-life.

ALLOY BASIS C, Mn, Ni.

STRUCTURE Weld-metal contains Austenitic Manganese steel deposit.

TYPICAL APPLICATIONS Buffer layers on worn out components of Manganese steels.

HARDNESS As Welded 22 to 25 Rc.
Work hardened to 48 to 50 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 – GOLD

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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