

Specially “ARCING and ROUGHING” electrode for welding of crushing rollers in the running plant.

CLASSIFICATION : DIN 8555 E10 UM -60 GR

Basis Alloys : - C, Cr,

CHARACTERISTICS : Unique electrodes deposit weld metal resistance to heavy abrasion and metal to metal wear of mild and low alloys steels. It's eliminated costly and time consuming problems in sugar industry. This electrode deposit a dispersion of small, hard with highly wear resistant globules for roughing the metal surface. The weld is dense, sound and non machinable type. Electrodes easy operating characteristics on AC as well as on DC (+) welding current.

APPLICATION:

1. Surfacing of worn-out part subject to high temperature abrasion.
2. Erosion, metal to metal wear and Impact.
3. Foundry parts, agricultural and earth moving equipments.
4. Construction, power plant, brick and cement industries.
5. Plough shares, dragline bucket lips, mixer blades, conveyor and screws.
6. Coal Crushing hammers, air rings, cane Knives.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hour,

ALL WELD CHEMICAL COMPOSITION %

C	MN	Si	Cr
3-4	1.50 max.	1.00 max	28-32

WELD METAL HARDNESS:

As welded Hardness
52-62 HRC

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Die)	Size(inch) (Die)	Current Condition (DC+/- AC) Amps	weight of packet (Kgs)	Weight of Case
3.20	1/ 8"	100-130	5	20
4.00	5/ 32	150-180	5	20
5.00	3/ 16"	210-260	5	20

Customer packing on request.