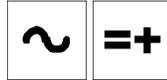


Coating type:

Basic

Arc voltage: 50V

Current:



Tip colour:

-

Welding positions:



Printing:

SUGARHARD E10-UM-60-GR

Sugarhard is our basic coated high efficiency (205%) electrode for roughening the wet mill rollers used in the sugar cane crushing process. Striking the arc with Sugarhard is very easy and the welding characteristics are superb in the environment to which the electrodes are exposed. The welding is done with a striking arc roughening the roller surface during processing with wear resistant chromium carbide globules; hardness of pure deposit weld metal is 63 HRc.

Applications:

Enormous rollers are used in the sugar cane crushing process and are subject to excessive wear during the season. These rollers have to be continuously welded, even when the process is in full swing. The roller, which is located near the end of the crushing process, is smothered in crushed, sludgy cane and its surface is wet. Sugarhard accommodates these conditions and deposits a dispersion of small, hard and very wear-resistant globules that fastens to the side walls of the ridges of the roller.

Roller arcing (welding method)

For arcing of sugar mill rollers you have to hold the Sugarhard electrode at right angles to the flans of the profile. Maintain contact with the electrode coating and the base material. Use "cold welding" technique, avoid excessive heat in the weld area.

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	W
3,5	1,0	4,5			20,0						

Mechanical properties, weld metal – typical:

Condition	Hardness
As welded	Deposit weld metal 63 HRc

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	450	72,4	110-130
4,0	450	104,0	160-210