

Classifications

Especial Development

Characteristics and Application field

Open-Arc flux cored wire for manual or fully automatic on-site "arcing" of sugar mill rolls in view of enhancing the gripping surfaces excessive wear taking place on the rolls during crushing. Special Chromium/Vanadium alloy and homogeneous droplet transfer.



Typical analysis in %

C	Si	Mn	Cr	V
2,00	1,80	1,20	7,00	0,50

Hardness

On Carbon Steel	~ 60 HRC
On Cast Iron	~ 66 HRC

Recommended welding parameters

		ø (mm)	Amperage (A)	Voltage(V)	Stick-out (mm)
		2,00	180 – 300	24 – 28	50 – 80
		2,40	230 – 380	28 – 40	50 – 80
		2,80	280 – 400	30 – 45	50 – 80