


SUGAR-825	HIGH CHROME CARBIDE ELECTRODE WITH MODIFIED WELDING CHARACTERISTICS FOR REPAIR WORK ON SUGAR CANE PROCESSING COMPONENTS			DATA SHEET NO. 125A					
SPECIFICATION									
CLASSIFICATION									
PRODUCT DESCRIPTION	<p>The design emphasis of the flux is designed to ensure a slag solidification range that allows the chrome carbide particles to be evenly distributed within the austenitic alloy matrix, so ensuring complete uniformity of hardness.</p> <p>The balanced lime rutile flux contains the appropriate alloying elements and is bound with a blend of silicates that ensures both coating strength and resistance to moisture absorption.</p>								
WELDING FEATURES OF THE ELECTRODE	<p>The electrode welds with a smooth stable arc and easily strikes and re-strikes. Weld appearance is bright, almost of polished appearance, smoothly contoured and slag detachability is excellent.</p> <p>The ease of re-strike and slag characteristics allow the electrode to be used for special pattern welding, eg: lattice or button type procedures.</p>								
APPLICATIONS AND MATERIALS TO BE WELDED	For surfacing of sugar mill feed roll, shredding knives and hammer bit. SUGAR-825 can be applied to repair the worn rolls during either running or stationary condition.								
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Fe
	MIN	3.0	1.5	-	-	-	25	-	
	MAX	4.0	2.5	0.75	0.03	0.03	30	0.75	
	TYPICAL	3.2	1.9	0.6	0.01	0.02	26	0.1	Bal.
WELD METAL HARDNESS (ALL WELD METAL)	AS WELDED 150 °C PRE-HEAT		HRC		HV		OTHERS		
	1 st Layer		48 – 52		480 – 550				
	2 nd Layer		50 – 56		520 – 620				
	3 rd Layer		54 – 58		580 - 660				
Actual hardness will be affected on base material composition, number of layers, heat input and welding conditions									
WELDING AMPERAGE AC or DC+	Ø (mm)	3.2		4.0		5.0			
	MIN	100		150		190			
	MAX	150		200		270			
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.								
RELATED PRODUCTS	Please contact our Technical Department for detail.								