


<b>SUGAR-827</b>	<b>HIGH CHROME CARBIDE ELECTRODE WITH MODIFIED WELDING CHARACTERISTICS FOR REPAIR WORK ON SUGAR CANE PROCESSING COMPONENTS</b>				<b>DATA SHEET NO. 125B</b>			
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	<p>For surfacing of sugar mill feed roll, shredding knives and hammer bit. SUGAR-827 can be applied to repair the worn rolls during either running or stationary condition.</p>							
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Fe
	MIN	3.5	1.0	-	-	-	25	
	MAX	4.5	2.0	2.5	-	-	35	
	TYPICAL	4.0	1.2	1.8	0.01	0.02	26	Bal.
WELD METAL HARDNESS (ALL WELD METAL)	AS WELDED 150 °C PRE-HEAT	HRC		HV		OTHERS		
	1 <sup>st</sup> Layer	48 – 52		480 – 550				
	2 <sup>nd</sup> Layer	50 – 56		520 – 620				
	3 <sup>rd</sup> 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.							