

Ratna Azucar 80

CLASSIFICATION

- A 5.13 2000 EFE CR A4
- DIN 8555 E10-UM-55-GPR

APPLICATIONS

- Sugar mill roll roughening
- Excavator bucket lips and teeth, dragline buckets
- Conveyor screws, rock chutes etc.

DESCRIPTION

- AZUCAR 80 deposits a tough eutectic of austenite and metal carbide that can withstand impact at medium loads under abrasive conditions. The weld metal has a hardness of approximately 550 HV (52 HRC), which it can retain up to 400°C.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)			
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)
3.00-4.00	0.50-2.00	1.00	27.0 min

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS HRC
49-59

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
3.2mm x 350mm	1/8" x 14"	110-160
4.0mm x 350mm	5/32" x 14"	140-180

RE-DRY CONDITIONS

- Re-dry the electrode at 250°C-300°C for 1 hour.

NOTE:
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