

Specification / Classification Code

EN 14700

T Z Fe8

Characteristics

Alloy designed specifically for semi or fully automatic on-site "arc-ing" of sugar mill cane crushing rolls in view of enhancing the gripping surfaces and prevent excessive wear taking place on the rolls during crushing. The deposit will show stress relief cracks.

Microstructure: Primary Eutectic carbides enhanced with Vanadium carbides

Machinability: Grinding only

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding Gas / flux: Open arc, self-shielded wire, external shielding of gas or flux is not needed.

Typical Application

Arcing or roughing of sugar cane crushing rolls

Typical analysis in %

C	Si	Mn	Cr	V	Fe
3.0	1.50	0.5	8.2	0.3	balance

Typical mechanical properties

Hardness as welded: 58 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
2.80	300-380	26-30	35-40

Size & Packing

Product #	Wire diameter [mm]	Pack
	2.80 mm	25 Kg spool
	2.80 mm	250 Kg Autopack (Drum)