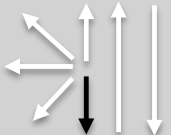


Classifications				
DIN 8555		EN 14700		
E 10-UM-60-G		E Fe14		
Characteristics and field of use				
<div><div>➤</div><div>This electrode is designed especially to meet rougher the sugar milling rolls by applying a hard coating in the form of small globules in the surface of the teeth of the mass reducing thus dramatically the sugarcane slippage.</div></div> <div><div>➤</div><div>This electrode has a specially designed flux as characterized by a rapid ignition and re-ignition, needed to cross the discontinuities caused by grooving of the masses. It hard coat globules deposit, have the right size for a good drag of the sugarcane, without having to open the combs.</div></div>				
Typical analysis of all weld metal (Wt.-%)				
C	Si	Mn	Cr	Fe
3.5	1.2	2.5	28	Balance
Mechanical properties of the weld metal				
Hardness of the pure weld deposit After welding			Approx. 60 HRC	
Welding instruction				
<p>The masses can be coated, either mounted on the mill, about or in any rotating mechanism that allows the mass rotate at a speed of 5-20 cm/min and the operator has free access to the application. Hold the electrode vertically as much as possible and the short arc when application UTP S 718 S. Moist electrode have been exposed to the environment must be dried at 300°C at 2 hr.</p>				
Welding positions				
<div><div></div><div>Current type DC (+) / AC</div></div>				
Approvals				
-				
Size, Packing and Recommended welding parameters				
Size mm	Kg / Pack	Kg / Box	Amperage (A)	
3.25 x 350	4.6	18.4	120 – 150	
4.00 x 450	6.0	24.0	140 – 170	
5.00 x 450	6.2	24.8	170 – 200	