

Classifications

Special Development

Characteristics and field of use

The UTP S Vanadium 500 is a stick electrode for arcing on sugar mill rolls in the sugar cane industry. A soft transfer with exact sizes of the drops improves the grinding of sugar cane. A special Chrome/Vanadium alloy offers excellent resistance against abrasion. It works with amperages lower than the conventional ones.

Typical analysis of all weld metal (Wt.-%)

C	Cr	V
5.0	22.0	0.5

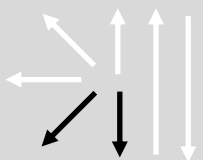
Mechanical properties of the weld metal

Hardness of the pure weld deposit	Approx. 60 HRC
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Welding Instruction

The current setting for rational and efficient applications should be respected.

Welding Position



Current type DC (+) / AC

Recommended welding parameters

Electrode \varnothing x L [mm]	3,25 x 350	4,00 x 450	5,00 x 450
Amperage [A]	100 - 140	140 - 170	170 - 200