

## Classifications

Special Development

## Characteristics and field of use

Electrode for hardfacing based on chromium and vanadium carbides, designed to resist extreme abrasion and corrosion caused by grinding sugar cane and increasing the productivity and life of the sugar mill rolls. Arcing with UTP S Vanadium SG leaves the surface of the teeth of the milling rugged and improve the "grip", which represents a considerable increase in tonnage of sugar cane milled, providing the maximum use of the bagasse.

The special coated of this electrode produces an aggressive arc, high penetration and can be applied with the grinding equipment. High rate of overcoating of the sugar mill rolls surface with drops of the exact size for the increase of the grip of the sugar cane. UTP S Vanadium SG works with amperage lower than conventional. Excellent resistance to abrasion.

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

C	Si	Cr	V
3.8	1.8	28.0	0.6

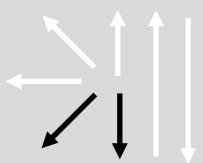
## Mechanical properties of the weld metal

Hardness of the pure weld deposit      Approx. 60 HRC

## 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