



Sugar Mill Journal

## High strength electrode for joining and surfacing of dissimilar steels and overlay on low alloy steels

### Typical Applications:

Sugar mills rolls, bearing areas of shafts, joining dissimilar steels.

### Outstanding Features:

- Immunity to corrosion by sugarcane juice.
- Deposits readily machined to high polish.
- Low co-efficient of friction.

### Recommendation:

Specially developed for surfacing of sugar mill crusher roll journals. Also suitable for joining and overlay of industrial machinery components fabricated from low/medium carbon steels, low-alloy steels etc. Complete freedom from cracks with multi-pass build-ups.

### Procedure:

Clean weld area. Remove all fatigued and cracked metal. Bevel heavy sections 60° Vee. Using short arc, deposit short beads, removing slag between passes. Prevent localised heat build-up by staggered welding sequence.

### Recommended Amperages:

Size(mm)	I-Range
2.50	40-70
3.15	70-100
4.00	90-140
5.00	140-180

**Tensile Strength:** 58 Kg/mm<sup>2</sup>  
(82,500 psi)