



Mill Roller

Special electrode for improving gripping & wear protection of sugarcane crusher roll teeth

Typical Applications:

Gripping & wear production of sugarcane crusher roll teeth "in situ" & with "juice-on".

Outstanding Features:

- Very good arc strike / re-strike & operating stability, even through juice & bagasse residues are present. No slag.
- Uniform weld hardness, which increases in service due to work hardening. This effectively controls roughness of roll teeth to increase juice extraction & productivity.
- Improvement in service life of rolls due to optimum metallurgical structure of the weld metal against adhesive wear.
- Medium size of weld globules ensures long life of trash plate as well.

Recommendation:

Suitable for crusher rolls manufactured from cast iron or steel.

Procedure:

Apply SuperGrip, with crusher roll in operation at a speed of 4-8 RPM. Deposit weld globules on sidewalls of the teeth, maintaining contact of electrode with the roll all the time. Keep the electrode inclined about 30° of the roll movement. The rolls do not require cleaning before / after welding.

Recommended Amperages:

Size (mm)	Amperage	
4.0 x 455	150 - 200 (Dry Arcing)	180 - 220 (Wet Arcing)

Hardness: 50 - 60 HRc