



MAGANACANE

HARD FACING (High Abrasion)



Special Hardfacing Electrode for Spot Arcing of Sugar Mill Rollers

ALLOY BASIS :

Very High Carbon-Chromium

KEY FEATURES :

- Basic type super heavy coating
- Special design to resist heavy loads produced during cane crushing in sugar mills
- Electrode strikes easily even on wet mill rollers
- Non machinable deposit
- Deposits hemispherical dots on the rolls which imparts better grip during cane crushing
- Faster build up due to high deposition rate

WELDING POSITION :



AC (100 V) / DCEP

TYPICAL APPLICATIONS :

- For Spot-Arc building/roughening Sugar mill rolls, chilled cast iron rolls
- Reclamation of Sand mixing blades, Scrapers, Screw flights, Mixing paddles

PHYSICAL PROPERTIES:

Condition	Hardness HRc (BHN)
As Welded	55-57 (550-580)

Machinability

Abrasion Resistance

Impact Resistance

Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 450	110-130	5	4	20
4.0 x 450	160-210	5	4	20
5.0 x 450	220-280	5	4	20

Physical Properties: With increase in number of squares, property improves