

# SUGARMATIC

## WELDING ROD MADE WITH CHROMIUM CARBIDE TO RECONDITION SUGAR MILL ROLLERS.

**APPLICATIONS:** This is a welding rod with a high chromium carbide content. It is highly abrasion and friction resistant either in low or high temperatures. Its filler metal can be deposited on any kind of steel, including austenitic high manganese steel. Due to its outstanding wear resistance, it is not necessary to carry out thick cladding. One or two layers will do to achieve good economic results.

**CHARACTERISTICS:** Vilchis Sugarmatic has a low hydrogen content covering and a high chromium carbide content. It is intended for application with either AC or DC reverse polarity. It is ideal for reconditioning carbon steel parts like in stone mills for quartz, silicates and carbonates, cane cutting blades, centrifugal pumps, excavator parts, dredgers, plow shares, cultivators, etc. Due to its low hydrogen content covering and chromium carbide content, fast and pore free cladding can be achieved without the risk of filler metal cracks.

**PROCEDURE:** Clean the joint area. You need not preheat the part since it is possible to use a higher AMP with this welding rod to allow the filler metal to flow properly. Use a medium arc and remove the slag between one pass and the next. It is recommended to make rows of weld beads or woven weld beads, not wider than twice the welding rod diameter.

<b>ROCKWELL HARNESS "C":</b>	FROM 57 TO 63
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b>	AC or DC REVERSE POLARITY
<b>ABRASION RESISTANCE:</b>	HIGH
<b>FRICTION RESISTANCE:</b>	EXCELLENT

FILLER METAL CHEMICAL ANALYSIS %				SIZES	AMPERAGE
<b>C</b>	<b>Cr</b>	<b>Mn</b>	<b>Si</b>	3.25 mm - 1/8"	110-130
3.10	37.0	0.89	2.17	4.0 mm - 5/32"	140-175
				5.0 mm - 3/16"	230-300