



NOVA™

TECHNICAL INFORMATION

N-SW Sugarweld Electrodes

A specially formulated hardfacing electrodes for sugar mill machinery and allied equipment. It is most ideal for rebuilding of sugar cane crusher rolls and other wearing parts of sugar mill equipment. Hardness : 56 - 60 H.R.C.

- Special features** :
1. Excellent for high impact and high temperature applications under corrosive medium.
 2. Can deposit even if the mill rolls are in motion.
 3. Iron base alloyed with manganese and chromium contents.

TYPICAL ANALYSIS OF ALL-WELD METAL DEPOSIT

Element	<u>C</u>	<u>Si</u>	<u>Mn</u>	<u>Cr</u>	<u>W</u>
Deposited Metal %	3.20	1.22	1.88	24.8	1.20

- Ampere settings** :
- | |
|---------------------------|
| AC (70 OCV) or DC +. |
| 3.2 mm 120 - 150 amp |
| 4.0 mm 160 – 180 amp |
| 5.0 mm 220 - 250 amp |

* Set lower ampere for dry surface and higher ampere for wet surface.

The data published are to our best knowledge the correct information. We reserve the right to alter the specifications at any time and without prior notice.