

ARCALOY SUPER AC/DC

PRODUCT DESCRIPTION :

Arcaloy super is an indigenously developed 'high recovery' electrode for the sugar industries to deposit 'hard droplets' on tooth points of cane crusher rollers. Higher coefficient of friction (between bagasse and roller teeth) increase the incidence of friction providing extremely good gripping property for the rollers.

PRINCIPAL APPLICATION:

Specially designed for 'arcing' of cast iron and cast steel sugar mill crusher rollers. Excellent weldability for 'wet' and 'dry' arcing. Self regulating arc on moving rollers results in better and precisely controlled deposits of conical droplets on tooth contours providing a firm anchorage to sugarcane on wet surface. Arcaloy is made up of complex carbides to resist wear by abrasion, adhesion, impact compression and corrosion.

PROCEDURE :

Set lowest possible welding current with in the range. Hold electrode almost vertical to the moving roller. Deposit weld 'droplets' holding a very short arc gap. Roller should be roated at 4-5 RPM. Deposits leave little or no slag.

TECHNICAL DATA : ARCALOY SUPER AC/DC

Size (mm) Ø	4.0	5.0
Hardness	Carbides 1500 VPN, Matrix x 700 VPN	
Coating Colour	Black	
Tip Colour	Grey	
Welding Current (Amps)	150 – 200	

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