

Postalloy® 2821-MCO Sugar Mill Roll Arcing Roughening Wire Ficha de Datos

by Postle
Postalloy
HARDFACE TECHNOLOGIES®

Postalloy® 2821-MCO is a chromium carbide hardface alloy that produces a "Spatter Weld" (Chapisco), from small to large to enhance the gripping action. This versatility can meet the needs of all desired sugar mill roll rough surface requirements for pulling the cane during processing. It is easily applied during production or in shop roll maintenance. An ideal alloy for applications involving high abrasion and moderate impact.

Especificaciones

Tipo de producto

Wire: Metal-cored, open-arc.

Propiedades de la soldadura

Hardness: 45Rc for 2 layers

Applications

SugarMill Rolls (Chapisco)

Postalloy® 2821-MCO Sugar Mill Roll Arcing Roughening Wire Configuración de soldadura

Current: DC Electrode Positive

Diameter	Amps	Volts	Stick Out
1/16" (1.6mm)	175-300	22-28	1"-1¼"(25-32mm)
3/32" (2.4mm)	250-350	23-26	1"-1½"(25-38mm)

Procedimiento de soldadura

When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover may be useful, especially when using a constant current power source and voltage sensing feeder.

Opciones de embalaje

Diámetro	Empaque estándar	Empaque disponible
1/16" (1.6mm)	25 lb spool	110 lb drum, 220 lb drum
3/32" (2.4mm)	55 lb coil	

