

**Technical data sheet**

160222JMBA

**Coated SMAW Electrode  
WA HARDFACE ZUCAR-E****CLASSIFICATION**

EN 14700: E Fe14

**DESCRIPTION**

- High-recovery basic coated electrode, specially designed for hardfacing or "Roller Arcing" of sugar mill crusher rolls
- High arc quality and weldability with little slag gives easy arc re-ignition even on wet rolls
- Tough, wear-resistant deposit, alloyed with carbide-forming elements.
- Resistant to friction, abrasion and corrosion
- The weld deposit retains its roughness during sugar cane crushing, ensuring maximum "grip".

**APPLICATIONS**

Specially developed for "roller arcing" sugar mill rolls during "pre-arcing" or whilst crushing. Hemispherical spot welds give excellent grip on materials such as sugar cane. Also suitable for hardfacing crusher hammers and other crushing equipment, augers, conveyor screws and earthmoving components such as bucket lips and ground engaging tools. It deposits a tough, wear-resistant alloy which combats wear on components subjected to heavy abrasion and moderate to heavy impacts.

**TYPICAL ALL-WELD METAL ANALYSIS [%]**

C	Mn	Si	Cr	Fe
3.5	2.0	1.0	30	Bal.

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Hardness as welded: 60 HRc undiluted

**OPERATING CONDITIONS**

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	120 - 150	140 - 170	170 - 220
= +	~ 50V		

Use a short arc and hold the electrode at 80° to the workpiece. Use a low current to limit dilution.

**WELDING POSITIONS**

EN ISO 6947: all positions except overhead

ASME IX:

**PACKAGING**

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	6.5	6.5

Other packaging and other sizes: please consult us