

Technical data sheet

011121MBA

Cored welding wire

HARDFACE ZUCAR SPATTER MAKER**CLASSIFICATION**

There are no standards for this type of product

DESCRIPTION

- “Open arc” cored wire designed for cane sugar rollers arcing
- During the arcing process, ZUCAR SPATTER MAKER produces molten metal spatters. Those spatters are, due to the specific arc transfer, strongly projected onto the base metal where they weld
- Increase of the surface roughness (gripping action) due to the high density and shape of the spatters
- Abrasion and semi corrosion resistant deposit
- Outstanding bonding onto lamellar graphite grey cast iron
- Designed for inter season (preventive / Dry arcing) and in operation (curative/ Wet arcing) applications

APPLICATIONS

- Arcing of groove flanks on cane sugar rollers
- Arcing of groove tips

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
4.2	0.6	0.2	22	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 56 – 58 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]	Voltage [V]	Stick-out [mm]	
	Range	Range	Range	Optimum
2.0	300 - 400	28 - 34	25 - 50	38
2.8	400 - 600	34 - 44	25 - 50	45

WELDING POSITIONS

Flank arcing: position “16h”; 45° angle torch

Tip arcing: position “12h”; 22.5° angle torch

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	Spool EN ISO 544: BS 300	Coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.