



ARCWEL 640- SMAW EN 14700 : E Fe 14

SUGARCANE CRUSHER ROLL – ARCING –HARDFACING

- Stick (SMAW) electrode to improve the **gripping** & wear protection of sugarcane crusher rolls,
- **Increases crushing efficiency and roller life.**
- High compressive strength and good weldability
- **Wear resistant chrome carbide deposits,**
- High resistance to corrosion ,adhesion &friction
- Excellent bond on steel or cast iron roller shells
- Special coating allows for rapid deposition of weld globules and easy striking and re striking of arc.
- **Hardness : HRC ~ 61, HV 700-740**
- Weld metal composition

| | | | | | | |
|---|----|----|----|---|----|----|
| C | Si | Mn | Cr | V | Mo | Fe |
|---|----|----|----|---|----|----|



Crusher roll arcing



Weld globules of ARCWEL 640

Packaging - Sizes- Current

| Sizes Ø x L | 3.2x350 | 4.0x450 |
|-----------------|---------|---------|
| Kgs/ Packet | 5 | 5 |
| Packets/ carton | 4 | 4 |
| Kgs/ carton | 20 | 20 |

| | | |
|---------------------|---------|---------|
| Amperage (A) | 120-150 | 160-210 |
|---------------------|---------|---------|

| | |
|-----|-------|
| = + | ~ 50V |
|-----|-------|

Procedure:

Adjust Crusher roll speed 4-8 RPM. Deposit weld globules on sidewalls of teeth and maintain contact of the electrode with the roll. Keep electrode inclined at approx. 30 ° below horizon in direction of roll movement . When doing wet arcing increase recommended current by approx. 10 % . Can be used on AC/DC welding machines (OCV min. 50 V)

Disclaimer/ Warranty.

The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties.

Arcwel reserves the right to alter specification without further notice. Health & Safety :

Observe safety regulations (fumes) MSDS available on request www.arcwel.com E-mail: info@arcwel.at