

ESSEN® 100

Hard facing electrodes For effective surface treatment

A Special Product

An Electrode Having Excellent Resistance to Impact, Abrasion, Corrosion, Heat, Cavitation etc.



PROPERTIES

ESSEN 100 / AZUCAR 100 is an electrode having excellent resistance to Impact, Abrasion, Corrosion, Heat, Cavitation etc

MECHANICAL PROPERTIES

57 - 60 Hrc

APPLICATIONS

ESSEN 100 / AZUCAR 100 has been specifically designed for use in Sugar Milling Industry for the facing of cane Knives, Fiberizer hammers and Shredder Hammers. It can however be used in a variety of applications which include the facing of excavator bucket lips and teeth, drag line buckets, screw conveyors, rock chutes, trash plate and scraper plate teeth etc. Also for number of applications in Steel, Power, Cement, Paper and Mining Industries.

WELDING PROCEDURE

No pre heating is required when the carbon equivalent of the material to be surfaced is below 0.3 (i.e .steels having a low carbon and manganese content with no alloying elements). The amperage should be kept as low as possible to obtain satisfactory bead profile. Relief checking is normal but can be aggravated by using low currents and high travel speeds. For maximum effect the beads should be arranged to 90 degrees to the working direction where possible.

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	120 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps

PACKING	
3.15 mm x 350 mm 5 kg	20 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	14 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

ESSEN® PRODUCTS ARE MANUFACTURED AND SUPPLIED
ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
TM REGISTERED IN INDIA BY: M/S. ASUGAR ENGINEERS PVT. LTD.
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