



PRODUCT DATA SHEET

WCD 7064

HARD FACING ARC WELDING ELECTRODES

Roller Rod



SUMMARY

- > Maintenance Electrode for Sugar Mill Rollers
- > Tough, Wear Resistant Martensitic Chromium Carbide Iron Deposit
- > For Hard Surfacing Components Subjected to Extreme Abrasion and Moderate to Heavy Impact
- > Highly Erosion Resistant
- > Designed for Wet Applications in Mining and Crushing

IDENTIFICATION

Coating - Black **End Tip** - Plain

CLASSIFICATION

- > AS/NZS 2576: 2560-A4
- > WTIA Tech Note 4: 2560-A4

DESCRIPTION

Roller Rod maintenance electrode for the hard surfacing of in service sugar mill rollers. Often used “in situ” during cane crushing. The Martensitic chromium carbide iron deposits of Roller Rod gives mill roll teeth an enhanced gripping action. Deposits have exceptional abrasion resistance and withstand moderate to heavy impact levels.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE* (AMPS)	ARC VOLTAGE RANGE (VOLTS)**
5.0	450	190 - 320	24

*Recommended for DC+ or AC (minimum 55 OCV) operation
 **Voltage is determined by arc current and electrode arc length.
 Arc voltage shown are typical and are only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Si	V	B	Fe
3.0	1.0	20.0	1.0	0.4	0.2-0.3	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Single Layer	Typical Hardness 61-62 HRc
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APPLICATIONS

- > Sugar Mill Roll Roughing
- > Bucket Teeth

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
5.0	5	15	6	RRD50

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