

HABCO ZUCKER 60 PLUS

ZUCKER 60 PLUS HAS BEEN SPECIFICALLY DESIGNED FOR THE DOT DASH METHOD OF HARDSURFACING SUGAR MILL ROLLS

METAL RECOVERY 170%+

FEATURES

HABCO ZUCKER 60 PLUS is a high efficiency chrome carbide and silicon carbide electrode designed exclusively for the hardsurfacing of lamellar graphite cast iron sugar mill rolls. The **spray-like droplet** transfer allows for the dotting of the filler metal onto the rolls with minimal slag. The dual flow coating produces a high metal recovery in excess of 170% while providing excellent fusion to the base metal without breaking or spalling off during grinding. The deposit gives the desired roughness to grip cane and pull it through faster, thus increasing the service life of the rolls, and greatly increasing production rates.

APPLICATIONS

For surfacing of new and used sugar mill rolls. Ideal for **dot-dash method** on the sides and tips of the roll teeth, feeder rolls and crusher parts. Can be deposited on the mill rolls, even where cane juice and cane fibers are present. **HABCO ZUCKER 60 PLUS** is designed to be applied during the crushing process, allowing for uninterrupted production until a scheduled maintenance shut down occurs.

INSTRUCTIONS

Welding should be done in flat or horizontal position. A medium arc gap should be maintained, with a three-pass maximum build up. The minimal slag does not have to be removed between passes. Tapping of the electrode to the base material to leave wear "dots" is recommended.

Hardness as deposited: 58-63 Rockwell C

Grinding Abrasion Resistance: Excellent

Current: AC or DC \pm

Amperage:	200-300	210-350
Diameters: (in)	5/32" x 18"	3/16" x 18"
(mm)	4.0	5.0