



## SUNHARD-250

### CLASSIFICATION:

Hardfacing Electrodes

Typical Weld Metal Hardness: 240-280 BHN on mild steel two layers.

### DESCRIPTION:

SUNHARD-250 is a basic coated AC/DC(-) type electrode producing an air hardening type weld metal for hard facing of carbon and low alloy steels. The weld metal is highly resistant to abrasive wear and has a fair degree of toughness.

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)			
C	0.20	Mn	1.0
Si	0.40	Cr	1.80

### TYPICAL APPLICATIONS:

Ideal for rail points and crossings, axles, wheels, gear shafts, couplings, pinion teeth, rollers, sprockets etc.

### CURRENT RANGE & PACKING DATA:

Size	Length	Current Range	Qty of Electrodes in a	Qty of Electrodes in a
(mm)	(mm)	(Amps)	Carton	Cardboard box
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-220	5 Kg	20 Kg

### PACKING:

Electrodes are packed in Cartons and four of these Cartons are shrink wrapped in a cardboard box.