

|                  |          |               |
|------------------|----------|---------------|
| <b>Standards</b> | DIN 8555 | E 10-UM-55 GR |
|                  |          |               |

**Approvals** ---

**Characteristics** CARBO Sugarrode is a heavy coated high efficiency hardfacing electrode with 180 % recovery. Suitable for applications subject to strong abrasive wear combined with moderate impact, medium shocks and compression as well as humidity or wetness.  
Prior to surfacing on old hard facing layers a buffer layer with CARBO 4370 MPR is recommended.

**Typical applications** Especially designed and mainly used for claddings in sugar mills, also for pump bodies, mixer blades and agitator arms.

|  |            |
|--|------------|
| <b>Hardness of all-weld metal</b><br>( typical values) | <b>HRc</b> |
|  | 50-60      |

|  |          |           |           |           |
|--|----------|-----------|-----------|-----------|
| <b>Weld metal analysis</b><br>(typical, wt. %) | <b>C</b> | <b>Si</b> | <b>Cr</b> | <b>Fe</b> |
|  | 3,5      | 1,0       | 29        | base      |

**Current** = + / ~ 50 V

**Welding positions** PA, PB

**Rebaking** 1 h, 350°C + / - 10 °C ( if required)

|                                   |             |
|-----------------------------------|-------------|
| <b>Flux-cored wire equivalent</b> | CARBO F- 53 |
|-----------------------------------|-------------|

| Dia./Length | Amperage (A) | Pcs./ packet | Pcs./ carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|--------------|--------------|-----------|-------------|-------------|
| 2,5 x 350   | 70 - 110     | 148          | 592          | 33,8      | 5,0         | 20,0        |
| 3,2 x 450   | 100 - 130    | 82           | 327          | 73,4      | 6,0         | 24,0        |
| 4,0 x 450   | 140 - 180    | 54           | 216          | 111,1     | 6,0         | 24,0        |
| 5,0 x 450   | 180 - 230    | 35           | 138          | 173,6     | 6,0         | 24,0        |
| 6,0 x 450   | 200 - 270    | 24           | 96           | 250,0     | 6,0         | 24,0        |

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