



**Shri Balaji Alloys
Corporation India**



MAXIDURA - SP

ELECTRODE FOR HIGH STRENGTH AND EXTREME CRACK RESISTANCE.

ALLOY BASIS

Fe, Ni, Cr, Mn, Mo

PROPERTIES

Electrode has very soft arc and gives smooth and defect free austenoferritic weld metal. Almost no distortion and embrittlement of the base material. The deposit is resistant to friction, heat and corrosion, is work hardening and shock proof. Practically no spattering and no undercut.

TECHNICAL DATA

Hardness of pure deposit - 200-220 Brinell

UTS of joint : 35-45Kgf/mm

Elongation : 22-24%

Ferrite Content - 30% Approx

TYPICAL APPLICATIONS

Heavy machinery parts, Earth moving equipment parts, automobile springs, trunnions of cement mill and other allied components, parts subject to heat, corrosion of impact. Joining and surfacing of high carbon, low and high alloys steel, tool steels, spring steels, manganese steel, case hardening steel, high speed steels, cast steels and for difficult to weld steels and unidentified steels. For joining of such steels with one another. Surfacing Of Grooved rolls and the repair of drop forge died gives very good results. As a cushioning alloy under hard deposit.

WELDING CURRENT

CURRENT : AC/DC(+)

Size (mm)/Length : 3.15×350 4.0×350 5.0×350

Current (amps) : 70-110 90-140 130-180

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