



NEXA-22RJ

**FOR WELDING SUGAR MILL ROLLERS JOURNALS,
MACHINERY COMPONENTS AND BEARING AREAS.**

ALLOY BASE : Fe, Cr, Ni, Mo

SPECIAL FEATURES

All position electrode giving Cr/Ni/Mo weld deposit providing high strength, excellent resistance to chemical corrosion and heat.

APPLICATIONS

Specially developed electrode for multi pass crack free buildup of sugar mill roller journals, machinery components and bearing areas. Smooth and steady deposition at lower currents. For cladding carbon steels to improve their wear and corrosion resistance due to sugar cane juice, water and other contaminants.

PROCEDURES

Clean weld area; remove all fatigued and cracked metal. For heavy thickness bevel 90°C groove. Stringer bead technique with shortest possible arc length is recommended. Use DC+ for good ripple and finish.

TECHNICAL DATA

Tensile Strength : 55-66 kgf / mm²
Elongation : 30-45%

CURRENT RANGE (AC/DC+)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	60-100	85-120	120-150