



**WA. ALLOY CO.**

WASHINGTON ALLOY'S Quality Management System is Certified to **ISO 9001:2008** Cert # 05-R0925

# USA Sugar Rod

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



**American Welding Society**  
Sustaining Company Member



## ALLOY DESCRIPTION AND APPLICATION;

USA Sugar Rod with its specially designed formulation yields superior weld deposits for grinding mace teeth, mill rollers, hammers bits, shredding parts found in the sugar processing industry. These rods have a globular spray that will deposit elements that forms high-resistance to abrasion, corrosion, impact and high temperatures. Easy ignition and re-strike can be found in both dry and wet humid conditions as well as the mill in movement (3-4 rpm idea) or stationary. This Welder friendly rod is easy to use and shall be vertical to 20-30° angle and at 2 to 3 o'clock about 50° angle from horizontal. Lower end of the current range will be used for dry better prepared base metals while the higher end of the current range is needed for the wet poorly cleaned base metals.

## TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps
5/32" (4.0mm)	160-240
3/16" (4.8mm)	190-260

Arc Length = short arc, Flat use 25° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.  
When welding vertical reduce amperage 10-20%

## TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	4.65		
Manganese	1.25	Phosphorus	0.028
Silicon	1.65	Sulfur	0.012
Chromium	29.55	Nickel	0.465
Hardness		57-62 HRC	

Iron balance and all single values are maximum percentages

## AVAILABLE SIZES:

## SPECIFICATIONS; Washington Alloy Internal



**WA. ALLOY CO.**

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