

## WELDING ELECTRODES



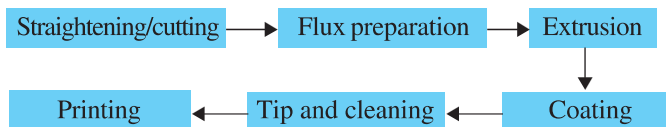
**Production capacity/annum**

1800 M.T.

### Production process

The electrode quality wire is straightened and cut to size and stored. The flux as per the formulation is to be prepared in the drier blender and wet mixer. Then the slug is to be made in cylindrical form in the automatic slug press. The slug is to be placed in the extrusion press and straight cut wires in the wire feeder hopper with the help of extrusion press. Flux is coated on the wire and passed through conveyer system and collected at the end.

### Process flow chart



### Machinery & equipment required

- Automatic slug press 90 MT
- Wire straightener
- Dry blender 1 MT
- Wet mixer
- Steel hopper, containers
- Oven with trolley

### Raw material/consumables required

- 4 mm core steel wire
- Sodium silicate
- Potash
- Rutile, Destrin
- Iron powder, Fluoride
- Starch powder
- Mica

### Utilities required

- Power required (load) : 30 KW
- Water required (per shift) : Normal supply

### Manpower required

- Supervisor : 1 No
- Skilled : 3 Nos
- Unskilled : 5 Nos

### Area required

- Total Area : 250 Sq. Mtr.
- Covered Area : 200 Sq. Mtr.

### Investment required

- Machinery & Equipment : } ₹ 78.1 Lakhs
- Working Capital for 3 Months : }
- (Raw material, utilities & salary)