



ID Fan

## Unique tubular electrode with high abrasion resistance property

### Typical Applications:

Coal burner nozzle, tips, crusher hammers, ID fans, grizzly bars, crusher housing, scraper blades, bucket teeth & lips.

### Outstanding Features:

- Specially designed for highest deposition rate and high metal recovery.
- Primary chromium carbides in hard martensitic matrix.
- Excellent resistance to abrasion & mild impact.
- Moisture resistant coating.

### Recommendation:

Ideal for severe erosive / abrasive wear resistance upto 250°C. The weld microstructure shows fine carbides uniformly distributed throughout the matrix. Required hardness & wear resistance can be achieved in single layer deposit.

### Procedure:

Clean weld area. Remove fatigued & worn metal. Pre-heat if required. Fine stress-relief checks are expected in the weld deposit. Use 40% overlap between adjacent passes when hardfacing entire area. Avoid excessive heating of the base material. Grind weld deposit for smooth surface finish.

### Recommended Amperages:

Size (mm)	I - Range
6.00	100 - 130
8.00	150 - 200

**Hardness:** 55-62 HRc (2 layer)