



Mill Pinions

## Anti-spalling weld deposit with excellent cushioning, good impact resistance & high compressive strength

### Typical Applications:

For built-up prior to hard facing for mill pinions, slide ways, hammers, wobblers, excavators, sprockets, rollers, shaft and gear teeth.

### Outstanding Features:

- Deposits have high compressive strength.
- An alloy for protective coating on all ferrous metals.
- High toughness and resistance to deformation.
- Rapid deposition in all positions.

### Recommendation:

An alloy for protective coating to resist severe impact on ferrous parts subject to heavy shock loading and pounding in service. Frigid Arc coating permits rapid weld metal deposition in all welding positions. Superior for field welding.

### Procedure:

Clean weld area. Use EWAC GougeTec electrode to remove fatigued or damaged metal. Preheat heavy section to about 150°C. Use stringer or weaving technique with a short to medium arc holding electrode at an angle of 60° to the horizontal. Do not allow excessive heat build-up. Chip slag between passes. Allow to cool slowly.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
4.00	130-140	110-125
5.00	160-175	135-150

**Hardness:** 25-35 HRC (3 layer)