Crusher Hammers

A versatile electrode with excellent resistance to impact with work hardening capability

Typical Applications:

Crusher hammer, wobblers, frogs, sprockets, bucket teeth, wear parts, shovel track pads, under carriage components, scraper blades.

Outstanding Features:

- Tough overlay on manganese steel and alloy steel.
- For severe impact, shock and hammering applications.
- Frigid arc coating for lowest possible amperage.
- Work hardens in service.

Recommendation:

A ferrous base electrode with additions of Ni, Mn & other elements to improve welding properties. Use on alloy steel as a cushion layer before hardfacing.

Procedure:

Clean weld area. Use EWAC GougeTec electrode to remove damaged metal. Do not preheat manganese steels. Maintain a short to medium arc length. On Mn steel keep bead length 75-100 mm at a time. Inter-pass temperature should be maintained below 150°C by following back-step technique. Skip welding is recommended on large parts. Peening while hot reduces residual stresses. Cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	120-140	100-120
4.00	160-190	130-140
5.00	180-200	160-190

Hardness: As deposited, 80-90 HRb (3 layer)
Work hardened, 35-45 HRc