



Crusher

## An advance work hardenable alloy with superior anti-impact property coupled with pressure and abrasion

### Typical Applications:

Track rollers, hydraulic turbines, crusher hammers, overhead gantry tracks, drive sprocket wheels, conveyor rolls, crossings and points, cushion layer applications prior to final hardfacing.

### Outstanding Features:

- High 'as-deposited' hardness.
- Work-hardens rapidly in service.
- Excellent crack resistance by absorption of internal stresses.
- Excellent ac/dc weldability and handling features.

### Recommendation:

A new high chrome-manganese alloy electrode for wear protection of carbon steels, alloy steels, etc. Also, ideal as cushion layer. The weld metal displays high 'as-deposited' hardness which increases further on work-hardening. The deposits are machinable with normal cutting tools.

### Procedure:

Clean weld area. Remove worn and fatigued metal. Use of EWAC GougeTec recommended. For medium carbon steels preheat upto 300°C, depending on carbon content and section thickness. Do not preheat austenitic manganese steels and interpass temperature should not exceed 150°C during welding. Using short arc and electrode tilted 10° in direction of travel, deposit stringer beads. Remove slag between passes and peen deposits.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	130 - 160	100 - 130
4.00	150 - 180	120 - 150

### Hardness:

As deposited, 15-25 HRc (3 layer)

Work hardened, 35-45 HRc (3 layer)