



Gear Teeth

A High alloy electrode for anti-wear protective coating & high strength joining

Typical Applications:

For joining: under carriage parts, sprockets, ripper shanks.

For Build-up: Gear teeth, Impactors, sprockets, trencher teeth, bucket teeth, hammers, augers, under carriage components, scrapper blades, crusher jaws.

Outstanding Features:

- Excellent resistance to impact and scoring.
- High work hardening rates.
- Excellent operating characteristics with fast deposition rate.
- Excellent crack resistance.

Recommendation:

A high alloyed electrode for similar & dissimilar joining, cladding and applications subjected to compressive service. Outstanding weldability with extra high deposition rate. Weld metal is completely machinable with tungsten carbide tools.

Procedure:

Clean weld area. Deposit stringer beads or use 2X weave pattern. Back whip to fill up craters and remove slag between passes. Peen deposits where maximum crack resistivity is required. Cool naturally. On 14% Mn steel, use skip welding or back step technique to prevent heating above 150°C.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	100-140	75-100
3.15	140-170	90-130
4.00	180-250	120-160
5.00	210-260	160-190

Hardness: As deposited, 80-90 HRb
Work harden, 25-34 HRc (3 layer)

Tensile Strength: 610 MPa (88,000 psi)