



Caster Roll

## Heat treatable alloy with good resistance to impact and compressive load upto 500°C

### Typical Applications:

Blast furnace bells (seat area), rolling mill rolls, shear knives, cable sheaves / pulleys, winches, crushing hammers, dredge cylinders.

### Outstanding Features:

- Hard, tough, crack-free machinable deposit.
- Balanced abrasion / impact / friction wear resistance.
- Heat - treatable.
- Abrasion resistance upto 500°C.
- Deposit machinable by carbide tools.

### Recommendation:

For multi-layer overlay on all types of plain carbon steels and ferritic / martensitic low and medium alloy steels. For “on-site” work including all position welding.

### Procedure:

Clean weld area. Remove old fatigued or damaged metal. Pre-heat heavy sections to 150°-200°C. Using short arc and electrode tilted at 10° in travel direction, deposit stringer beads. Back-whip craters and chip slag between passes. Allow to cool slowly. Large overlays can be stress-relieved by holding at 500°C for 6-8 hours, followed by slow cooling.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	110 - 150	90 - 130
4.00	160 - 180	140 - 160
5.00	180 - 200	160 - 180

### Hardness:

At 30°C 48 - 52 HRc (3 layer)  
At 400°C 42 HRc (3 layer)