



Bucket

## An advanced electrode for applications subjected to abrasive wear

### Typical Applications:

Pulverisers, skids, cement grinder rings, mill hammers, bucket teeth, excavator parts, screws, mixers scrapers.

### Outstanding Features:

- Dense and spatter-free deposit.
- Resists high abrasion.
- Rapid deposition.
- All position.

### Recommendation:

For weld protective coating subject to abrasive wear and moderate impact. For use on steel, manganese steel and malleable iron. Ideal for both new or worn parts, especially for multi-pass build-ups. All Position weldability.

### Procedure:

Clean weld area. Use EWAC GougeTec to remove contaminated, fatigued and damaged metal. Preheat heavy sections to about 200° - 250°C. Use stringer or weaving technique holding a short to medium arc. Long deposits may be made without danger of cracking. Do not allow excessive heat build-up. Chip slag between passes and allow to cool.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	95-100	85-95
4.00	125-150	90-115
5.00	175-200	140-165

**Hardness:** 56-61 HRC