



Stacker Reclaimer Bucket

A versatile electrode offers single layer hardness with superior abrasion resistance

Typical Applications:

Jaw crusher plate, excavator bucket, lips, teeth, fan blades, hammers, scrapper, augers, pulveriser.

Outstanding Features:

- Excellent resistance to abrasion.
- Smooth bead appearance.
- High resistance to erosion.
- Superior weldability with single layer hardness.

Recommendation:

For steel parts requiring resistance to severe abrasive wear. Deposits polish in service providing a very low co-efficient of friction & erosion resistance. Very smooth highly ionised spray transfer. All position welding electrode.

Procedure:

Clean weld area. Use EWAC GougeTec electrode to remove fatigue or damaged metal. Preheat if necessary. Deposit the alloy directly on base metal. Do not preheat on 14%Mn steels. Deposit a buttering layer of EWAC BU 102, inter pass temperature should be below 150°C. For air hardenable steel and cast iron, buttering layer of EWAC ST 207 & EWAC CI 422 should be deposited respectively. Restrict deposits to maximum 2 layers.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	110-130	90-110
4.00	150-170	130-150
5.00	180-200	160-180

Hardness: 60-68 HRc (3 layer)