



Stacker Reclaimer Bucket

## Very high abrasion resistant alloy with extra high deposition rates

### Typical Applications:

Reclaimer bucket, stacker bucket, dragline buckets, lips, tooth points, cutting edges, scraper blades, crushing hammers, conveyor chains, mixer blades, sludge pumps etc.

### Outstanding Features:

- High resistance to wear from combined abrasion, pressure and moderate impact.
- Easy handling, rapid deposition rate, very thin slag.
- Thick single pass deposits with extra high yield.

### Recommendation:

A unique electrode for anti-wear coatings on carbon steels and austenitic manganese steels. The weld deposits have very high content of hard constituents making extremely resistant to intense abrasion under pressure combined with moderate impact.

### Procedure:

Remove all damaged and fatigued metal. Maintain medium arc length and electrode vertical, deposit stringer or 1½ X weave patterns, back fill craters. Single pass overlay is normally recommended. If more build up is required, use cushion layer of EWAC BU 104 for steel, EWAC BU 102 for 14% manganese steels and EWAC CI 424 for cast iron. Use hard silicon carbide wheels for grinding.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	150-170	100-120
4.00	210-250	160-200
5.00	250-280	190-200

**Hardness:** 62-68 HRc (2 layer)