



Screw Edges

Scientifically engineered electrode based on Nano Technology, that exhibits extraordinary wear resistance given at elevated temperatures

Typical Applications:

Grizzly bars, exhaust fans, mixer blades, furnace chutes, scrappers, sinter crusher bars, sinter plant fans, screw conveyers and many other equipment from severe abrasion and erosion at elevated temperatures.

Outstanding Features:

- High single pass hardness.
- Exceptional abrasion & erosion resistance.
- Elevated temperature applications.
- Ultra - hard coatings with good toughness.
- Multi - layer deposits achievable.
- High deposition rate with high metal recovery.

Procedure:

Remove all damaged and fatigued weld metal with Chamferetrode and clean weld area. Maintain short to medium arc length and hold a near vertical electrode angle. Deposit stringer or 1.5 X weave beads. Back whip crater. For high carbon steels, preheat to 250 - 300°C maintain inter pass temperature to 150°C show cool after welding. Smooth and ripple - free deposit with micro-fissure stress relieving cracks.

Recommended Amperages:

Size (mm)	I - Range
4.00	130 - 170

Hardness: 67 - 71 HRc