



Kiln Tyre Crack Repair

Special flux coated electrode for joining and repair of heavy and massive sections and dissimilar steels

Typical Applications:

Rotary kiln tyres, hear treatment equipment such as retorts, racks, trays, tongs etc, earthmoving equipment, cryogenic equipment, joining dissimilar combinations of steels.

Outstanding Features:

- Suitable for both joining and overlaying.
- Excellent resistance to corrosion, oxidation and thermal shock.
- Extraordinary weldability without electrode overheating.
- Strong tough welds.

Recommendation:

For all steels including heat-treatable types, difficult-to-weld types and those with unknown composition. Also for nickel alloys and their dissimilar combinations. A key characteristic is that deposits are able to withstand stresses produced by thermal cycling or by strains caused by weld shrinkage in massive sections.

Procedure:

Clean weld area, removing all fatigued and damaged metal. Bevel heavy section 60° vee. Pre-heating necessary only for crack-sensitive base materials or massive parts. Deposit stinger or 2-x weaved beads using short arc and minimum amperage, backwhipping all craters. Chip slag between passes, wire brush and peen each deposit. Cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	90 - 125	80 - 90
3.15	130 - 170	110 - 130
4.00	160 - 200	140 - 160

Tensile Strength: 63 Kg/mm²
(90,000 psi)

Elongation: 30 - 35%