

Excellent Abrasion Resistance Alloy with Very High Deposition Rate

Typical Applications :

Reclaimer buckets, stacker buckets, 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
- Negligible slag

Welding 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 EHDP 92 for steel, EWACTRO BU 800 for 14% manganese steels and WUNDER 80 for cast iron. Use hard silicon carbide wheels for grinding.

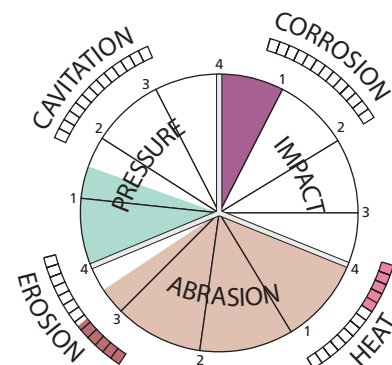
Recommendations :

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.

Tensile Strength : 62 - 68 HRc (2 layer)



Jaw Crusher



Abrasion	3½	Erosion	5½
Impact	1	Heat	5
Pressure	1½		

Recommended Amperage:

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

