

Open Arc Self-shielded Flux Cored Wire for Wear-facing Against Abrasion and Impact

Typical Applications :

For multi-pass intermediate layers and anti-wear coating on roller press rolls, crushers, tie tamping tools, cane knives, shredders, shovel buckets, augers & scraper blades etc.

Outstanding Features :

- High resistance to impact, pressure & abrasion
- Ideal for thick, multi-pass protective coatings
- Finely dispersed titanium carbides in tool steel type weld microstructure



Quenching Screw

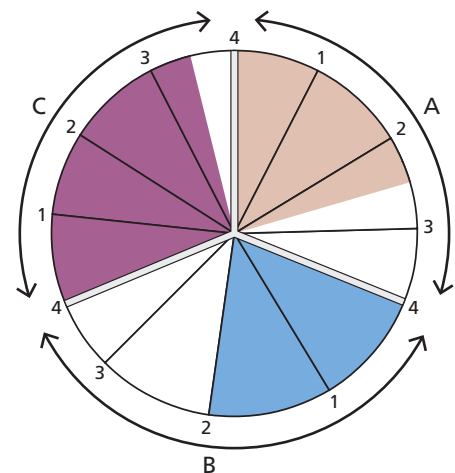
Welding Procedure:

After striking arc, weld with recommended electrical stick-out. For optimum deposit quality use stringer bead or moderate weaving technique. Break arc by rapidly lifting the torch away from the work piece.

Recommendations :

Unique martensitic Fe-Ti-Cr-C alloy for repairing of components subjected to high impact combined with severe pressure and abrasion in service.

Hardness : 52 - 58 HRC



- A - Abrasion 2½
- B - Friction 2
- C - Impact 3½

Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
1.6	27 - 30	170 - 220	20 - 30
2.8	28 - 32	260 - 340	50 - 65

