



Bucket Teeth Adapter

Unique tubular electrode with high abrasion resistance property

Typical Applications:

Coal burner nozzle, tips, crusher hammers, ID fans, grizzly bars, crusher housing, scraper blades, bucket teeth & lips.

Outstanding Features:

- Specially designed for highest deposition rate and high metal recovery.
- Primary chromium carbides in hard martensitic matrix.
- Excellent resistance to abrasion & mild impact.
- Very high current density due to tubular design.
- Very high force at low temperature.

Recommendation:

Ideal for severe erosive / abrasive wear resistance upto 250°C. The weld microstructure shows fine carbides uniformly distributed throughout the matrix. Required hardness & wear resistance can be achieved in single layer deposit.

Procedure:

Clean weld area. Remove fatigued & wornout metal. Pre-heat if required. Fine stress-relief checks are expected in the weld deposit. Use 40% overlap between adjacent passes when hardfacing entire area. Avoid excessive heating of the base material. Grind weld deposit for smooth surface finish.

Recommended Amperages:

Size(mm)	Amperage
6.00	100-130
8.00	150-200

Hardness: 55 - 62 HRc (2 layer)