



Debarker Ribs

## Tungsten carbide based tubular electrode for severe abrasive wear

### Typical Applications:

For hard-surfacing of fans and pump impellers, pug mill augers and knives, sand and gravel chutes, tongs, feed screws, ripper teeth and scraper mixer blades.

### Outstanding Features:

- Excellent operating characteristics.
- Dense, finely rippled weld deposits.
- Superior resistance to severe abrasive wear.
- Super hard overlays on all steels.
- High deposition rate & high metal recovery.

### Recommendation:

Specially developed high-alloy electrode of tubular design, yielding a weld deposit consisting of very hard, partially dissolved tungsten carbides in a tough, eutectic Fe-Cr-C alloy matrix. The weld deposits offer ultimate abrasive resistance combined with light impact.

### Procedure:

Use Eutec-ChamferTrode to remove fatigued or damaged material. Preheat heavy sections for 250°C. On dc, use reverse polarity, maintain a short arc length, incline electrode at an angle of 80 to 90° in the direction of travel and deposit stringer beads. Back-whip craters and extinguish the arc of weld deposit. Chip slag between the passes. When cladding large surfaces, use skip & stagger technique to prevent localized heat build up. For most applications, a single layer of weld metal is generally sufficient. The weld deposits are to be finished by grinding only.

### Recommended Amperages:

Size(mm)	Amperage
6.00	100-130

**Hardness:** 60 - 65 HRc (2 layer)