



Screw Conveyor

Open arc self-shield metal wed wire for hardfacing applications in construction and mining industries

Typical Applications:

Excavator teeth, dredger buckets, crushers, augers, conveyor parts, scrapper bars, exhaust blades.

Outstanding Features:

- Excellent resistance to grinding abrasion with compression and medium impact.
- Superior deposition efficiency.
- Ideal choice for field work or on-site applications.

Recommendation:

Steel parts requiring resistance to serve abrasive wear. Deposit polish in service providing low co-efficient of friction and abrasion resistance.

Procedure:

Remove any previous weld deposits or cracked material with Eutec-ChamferTrode. When deposits are directly applied to base metal, pre-heating upto 300°C is required. Do not pre-heat Austenitic Mn Steel.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
1.6	26-29	170-240	25-35
2.8	28-32	250-350	45-60

Hardness: 50 - 58 HRC (3 layer)