



Ring Type Coal Crusher

## Open arc self-shield continuous wire for build-up of table and roller liners.

### Typical Applications:

Coal mill crusher hammers, table liners, rolls and roller liners in cement plants as well as thermal power stations.

### Outstanding Features:

- Rapid deposition rate. No slag.
- Superior wear resistance.
- High hardness.
- High resistance to grinding abrasion.

### Recommendation:

Build-up of all table liners and roller liners. Repair of worn out or damaged profiles. Salvage of undersized liners by re-build with weld metal around 40 mm thickness.

### Procedure:

Clean weld area. Remove all foreign particles like limestone and coal etc. from the surface. Before starting welding, subject the job to non-destructive testing (Dye penetrant / Ultrasonic) for detecting any surface or sub-surface flaws. Use proper welding parameters like current, voltage, wire stick-out for producing sound quality weld build-up.

### Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
2.8	28 - 32	300 - 450	40 - 50

**Hardness:** 56 - 62 HRC