



Extruder Screw

Open arc self-shielded alloy wire containing niobium carbides for severe abrasive and erosive wear at elevated temperatures

Typical Applications:

for wear-protective coating of carbon steels, low or high alloy steels and 14% Mn steels.. Also for wide range of steel components subject to severe abrasion or erosion by mineral particles, sand, rocks, coal / coke and cement industries. Pneumatic conveyor systems, mixer blades, pump impellers, excavator bucket teeth, conveyor chutes, concrete mixers, asphalt handling etc.

Outstanding Features:

- Single pass provides optimum, intrinsic properties.
- Formation of stress relieving cracks to minimise distortion.
- Slag free deposits save weld cleaning time.
- Deposits are smooth, flat, grindable.
- Resistant to flame cutting - use plasma arc process.
- Excellent resistance to abrasion and erosion up to 450°C service temperatures.

Recommendation:

Self-shielded, flux cored alloy wire for maintenance and repair welding of thick, heavy components where faster weld deposition rates are required. This wire can be used either manually, semi automatic or fully automatically to increase productivity.

Procedure:

After striking, maintain the appropriate electrical stick-out as specified. For optimum deposit quality, use drag stringer bead or moderate weaving techniques to minimise overheating risks. Stop welding by rapidly lifting the torch away from the work-piece.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
2.40	26-30	250-300	30-40
2.80	28-32	260-350	35-45

Hardness: 60 - 68 HRC