



Jaw Plate

Open arc self shielded continuous wire designed to resist impact, galling and pressure

Typical Applications:

Drive sprockets, crusher rolls and jaws, track pads, hammers, dozer blades.

Outstanding Features:

- Versatile Cr-Ni-Mn alloy for rebuilding.
- Excellent resistance to impact, galling and scoring.
- High work-hardening rate without deformation.
- Excellent operating characteristics with fast deposition rate.
- Non-magnetic, readily machinable and exhibits very good corrosion resistance.

Procedure:

Clean the base metal. For joining bevel edges to 90°. Deposit stringer beads or use 2x weave pattern. Back whip to fill up craters. Remove slag between passes. Peen deposits where maximum crack resistivity required. On 14% Mn steels, use balanced deposition technique to prevent heating above 150°C.

Welding Parameters:

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

Tensile Strength: 55 Kg/mm²
(78,000 psi)