



Mill Body Liners

Tubular Electrode with High Temperature Tribological Properties

Typical Applications:

High temperature wear resistant coatings on all type of carbon steels and stainless steels. Sinter star crushers, Clinker conveyor chains, Hot slag conveyors, Sand and gravel chutes, Clinker wear parts, Pug mill augers and knives, Cement clinker plates, Feed screws, Grate bars, Sinter drums & tray, Coal burner nozzle, Coke pusher shoes, Exhaust fans, Mixer blades, Furnace chutes, Screw conveyors.

Outstanding Features:

- High Single layer hardness (65 HRc).
- Overlay with hot hardness retention properties
- High Wear factor 90 (ASTM G 65, Type A).
- Surfacing on inclined surfaces with skilled operator
- Can be deposited on low carbon steels, low alloy steels & Stainless steels.

Recommendation:

High temperature surfacing alloy containing heat treatable matrix capable of holding extra high volume fraction of multi-stoichiometry and morphology of ultra-hard wear resistant phases. This unique alloy in tubular form provides the best performance to enhance service life of components

subjected to high temperature wear conditions up to 800 °C.

Procedure:

Clean weld area by removing fatigued & worn out surface. Use minimum amperage while surfacing to minimize heat input and base metal dilution and warpage on thin sections. Weld with short arc to deposit stringer beads. Back whip craters. For high carbon steels pre-heat upto 250°C and maintain inter-pass temperature throughout welding. Use minimum 30% overlap between adjacent passes. Recommended upto 2 layers. Presence of fine stress relieving cracks may appear for this type of alloy system. Use low diameter tubular electrode for inclined positions. Smooth surface finish can be achieved by grinding.

Recommended Amperages:

Size(mm)	Amperage
6.30	80-120
8.00	140-180

Hardness: 65 - 70 HRc (2 layer)
(on MS); 58 - 63 HRc (on SS 304)