



Ring Type Coal Crusher

A versatile electrode for superior abrasion resistance

Typical Applications:

Jaw crusher plate, excavator bucket, lips, teeth, fan blades, hammers, scrapper, augers, pulveriser.

Outstanding Features:

- Excellent resistance to abrasion.
- Smooth bead appearance.
- High resistance to erosion.
- Superior weldability.

Recommendation:

For steel parts requiring resistance to severe abrasive wear. Deposits polish in service providing a very low co-efficient of friction & erosion resistance. Very smooth highly ionised spray transfer. All position welding electrode.

Procedure:

Clean weld area. Use Eutec-ChamferTrode electrode to remove fatigue or damaged metal. Preheat if necessary as per CE. Deposit the alloy directly on base metal. Do not preheat on 14%Mn steels. Deposit a buttering layer of EuteTrode 400, inter pass temperature should be below 150°C for Mn steel. For air hardenable steel use EuteTrode 670 as cushion layer. For cast iron use Xyron 224 as cushion layer. Restrict deposits to maximum 2-3 layers.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	110 - 130	90 - 110
4.00	150 - 170	130 - 150
5.00	180 - 200	160 - 180

Hardness: 60-68 HRc (3 layer)