



Kiln Inlet Tongue Plate

## Weld metal with outstanding abrasive wear resistance even at elevated temperature

### Typical Applications:

Sinter star crusher, grate bars, clinker conveyor chains, coke pusher shoes, augers, billet conveyor guides, hot slag conveyor, blast furnace hoppers, pug mill knives.

### Outstanding Features:

- Excellent resistance to abrasive wear at elevated temperature.
- Easy handling with high deposition rate.
- Thick single pass deposits with extra high yield.
- Very thin slag.

### Recommendation:

An advance electrode for overlaying of carbon steel and austenitic manganese steels for applications subjected to abrasion & erosion at elevated temperature. The deposit consists of high percentage of special constituents which retain abrasion resistance up to 650°C.

### Procedure:

Remove all damaged & fatigued weld metal and clean weld area. Maintain short to medium arc length, deposit stringer or 1½ X weave patterns. Back whip crater. For high carbon steels, preheat up to 250°C. Use XHD 646 as a cushion alloy if more build up is required. For austenitic manganese steel do not allow temperature of parts to rise more than 150°C & use EutecTrode 6450 as a cushion layer. Slow cool after welding.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	150 - 170	120 - 140
4.00	200 - 220	140 - 160
5.00	230 - 250	160 - 180

**Hardness:** 62 - 68 HRc (2 layer)