

**Crane Wheel Welding**

A rich alloyed electrode for wear protective coating and high strength joining.

Typical Applications:

For joining: Under carriage parts sprockets, ripper shanks.

For build-up: Gear teeth, impactors, sprockets, trencher teeth, bucket teeth, hammers, augers, under carriage components, scrapper blades, crusher jaws.

Outstanding Features:

- Excellent resistance to impact and scoring.
- Rapid hardening property.
- Excellent operating characteristics with fast deposition rate.
- Excellent crack resistance.

Recommendation:

A high alloyed electrode for similar & dis-similar joining, cladding applications subjected to compressive load service. Outstanding weldability with extra high deposition rate. Weld metal is completely machinable with tungsten carbide tools.

Procedure:

Clean weld area. Deposit stringer beads or use 2X weave pattern. Back whip to fill up craters and remove slag between passes. Peen deposits where maximum crack resistivity is required. Cool naturally. On 14% manganese steel, use skip welding or back step technique to prevent heating above 150°C.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	100 - 140	75 - 100
3.15	140 - 170	90 - 130
4.00	180 - 250	120 - 160
5.00	210 - 260	160 - 190

Hardness:

As deposited 80-95 HRB

Work hardened 28-35 HRC

Tensile Strength: 64 Kg/mm²
(90,000 psi)