EHDP ROD D2 ac/dc+

Kiln Tyre Crack Repair

Specially designed electrode for joining and repair of dissimilar steels and heavy sections

Typical Applications:

Rotary Kiln tyres, heat treatment equipment such as racks, trays, tongs etc, earthmoving equipment, cryogenic equipment, joining dissimilar combinations of steels.

Outstanding Features:

- Suitable for both joining and overlaying.
- Excellent resistance to corrosion, oxidation and thermal shock.
- Extraordinary weldability without electrode overheating.
- Strong tough welds.

Recommendation:

For all steels including heat-treatable types, difficult-to-weld types and those with unknown composition. Also, for nickel alloys and their dissimilar combinations. A key characteristic is that deposits are able to withstand stresses produced by thermal cycling or by strains caused by weld shrinkage in massive sections.

Procedure:

Clean weld area, removing all fatigued and damaged metal. Bevel heavy section 60° vee. Pre-heating necessary only for crack-sensitive base materials or massive parts. Deposit stinger or 2x weaved beads using short arc and minimum amperage, back whipping all craters. Chip slag between passes, wire brush and peen each deposit. Cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	90 - 125	8 0 - 90
3.15	130 - 170	110 - 130
4.00	160 - 200	140 - 160

Tensile Strength: 66 Kg/mm^2 (92,000 psi)

Elongation: 30 - 35%