

**Coal Mill Grinding Roll**

Self-shielded continuous wire having resistance to high impact and compressive load.

Typical Applications:

Track pads, crusher hammer, blow bars, bucket, track roller etc.

Outstanding Features:

- Optimum crack resistance.
- Excellent impact and abrasion resistance.
- Versatile joining and cushion layer for any protective coating.
- Work hardens in service.

Recommendation:

A high performance, flux-cored, self-shielded continuous electrode with excellent arc stability and high deposition rate. Designed for joining & overlaying of low alloy steel, carbon steels and austenitic manganese steel.

Procedure:

Clean weld area. Remove fatigued metal with EWAC GOUGETRO. Run stringer beads or skip weld to minimise heat build-up. Back whip to fill craters, clean slag, wire brush and peen each deposit. Cool naturally. Finish by grinding if necessary.

Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
1.6	26-29	170-240	25-35
2.4	28-32	200-300	40-60
2.8	28-32	250-300	45-60

Hardness (As Deposited):

16 - 25 HRC (3 layer)

Work Hardened:

32 - 47 HRC (3 layer)