



Feeding Screw Paddles

## Open arc continuous flux cored wire having outstanding abrasive wear resistance at elevated working temperature.

### Typical Applications:

Sinter handling equipments, coke pusher shoes, clinker conveyer chains, hot slag conveyers, billet conveyer guide.

### Outstanding Features:

- Smooth operating characteristics with negligible slag.
- Dense, fine rippled weld beads with multi-pass capability.
- High deposition rate & metal recovery.
- Excellent resistance to abrasion & erosion upto 650°C.

### Recommendation:

A high performance, metal-cored, self-shielded wire for automatic / semi-automatic hard facing of carbon steels, low alloy steels & austenitic manganese steels. The weld metal is rich in complex refractory carbides in eutectic matrix, which effectively withstands abrasion, erosion and corrosion in service.

### Procedure:

Clean the weld area. Remove worn and fatigued metal with EWAC GOUGETRO. Pre-heat if required. Use EWAC O 10 for buffer layer or for build-up. Run stringer beads or 2X weave pattern. Back-whip craters. Clean slag residues with wire brush. Do not peen deposit. Allow natural cooling. Finish by grinding.

### Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
2.4	28 - 32	200 - 300	40 - 60
2.8	28 - 32	250 - 350	45 - 60

**Hardness:** 58 - 65 HRC (2 layer)