



Carrier Roller

Open arc self-shielded flux cored wire for joining, and buildup applications.

Typical Applications:

Repair of machine base, housings, tanks, agricultural equipment maintenance of heavy mining and construction equipment, fabrication of wear parts.

Outstanding Features:

- Smooth operating characteristics with easily detachable slag.
- High deposition rate and efficiency.
- Smooth, well-rippled weld beads require minimal finishing.

Recommendation:

Continuous wire for rapid joining, fillet welding and build-up of low carbon steels in single or multipass applications. Deposit having high strength and are crack resistant (Not recommended for sub-zero temperature applications).

Welding Procedure:

Clean weld area. Remove earlier damaged metal. On heavy sections bevel to 90°. Preheat if required. Run stringer beads or use 2X weave bead technique. Backwhip to fill craters. Remove slag between passes. Allow natural cooling.

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 - 350	45 - 60

Hardness: 20 - 32 HRC

Tensile Strength: 58 Kg/mm²
(82,000 psi)