

**Swing Gear**

Self-shielded flux cored wire for welding of dissimilar steels and unknown steels.

Typical Applications:

Bearing housings, gears, jaw crushers plates, chains, apron feeders, baffle plates etc.

Outstanding Features:

- Optimum crack resistance on all steels.
- Good resistance to heat, corrosion and impact.
- Versatile joining and cushion layer for any wear protective coating.

Recommendation:

A high performance, flux-cored, self-shielded continuous electrode with excellent arc stability and high deposition rate. Designed for joining mild steel low and medium alloy steel, stainless steel & dissimilar steels.

Procedure:

Clean weld area. Remove damaged metal with EWAC GOUGETRO. On heavy sections, bevel to 90°. Preheat if required. Run stringer beads or use a 2X weave bead technique. Back whip to fill crates. 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	250-350	50 - 70

Tensile Strength: 78 Kg/mm²
(1,10,000 psi)