



Paper Mixer Screw

## Self-shielded open arc flux cored wire having superior resistance to abrasion and low-to-medium impact.

### Typical Applications:

For wear preventive protection of parts in the quarry, cement, sand and gravel, dredging, foundry industries: pump impellers, dredge cutters, rolls, crusher pinions and grinders, cement conveyor screws, hydro-pulpers, bucket shovel teeth and edges, dragline parts, chutes, mixer arms, scraper blades, screws, etc.

### Outstanding Features:

- Excellent resistance to abrasion combined with compression and impact.
- Double pass capability.
- Negligible slag residues to clean.
- Deposit is rust resistant and can be ground.

### Recommendation:

High chromium-carbon self shielded flux-cored alloy for wear-preventive protective coatings on low or high alloy steels and 14% manganese steels.

### Procedure:

Clean the weld area. Remove worn and fatigued metal with EWAC GOUGETRO. Pre-heat if required. Skip weld to minimise heat build-up. Chip slag & remove residues with wire brush 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:** 50 - 58 HRC (3 layer)