



Guide Roll

Open arc self shielded flux cored wire having good resistance to impact and compressive load upto 500°C.

Typical Applications:

For wear protective coating on drill bits, grab buckets, dragline teeth, leading edges, crusher hammers, strikers, ground augers, gravel pumps, conveyor screws, hot sand chutes, hot slag handling equipment, casting or billet handling machines, brick and tile moulds etc.

Outstanding Features:

- Tough, forgeable, magnetic deposits.
- Deposits are crack resistant and heat treatable.
- High deposition rate and easy slag removal.
- Maximum service temperature 500°C.

Recommendation:

Special heat treatable alloy steel, for wear protection with excellent resistance to impact and compressive loads. The special alloy constituents make this product suitable even at upto 500°C.

Welding Procedure:

Clean weld area. Remove fatigued & worn metal. Pre-heat if required (12%-14%) manganese steel should be welded in cold condition, the temperature should not exceed 150°C). Avoid excessive heating of the base material. Chip slag & remove residue with wire brush between passes. Allow natural cooling.

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: 52 - 58 HRC (3 layer)