



Grinding Path

Self-shielded open arc flux cored wire with high resistance to impact and pressure.

Typical Applications:

For multi-pass intermediate layers, anti-wear coatings, & joining thick steel parts of dissimilar composition. railway points, curved tramlines, crusher bars and jaws, gyratory crusher cones, hydro-turbines, cylindrical crusher jaws, drive sprockets, rolling mill guides.

Outstanding Features:

- High resistance to impact, pressure, metal to metal friction.
- Deposits with work hardening properties.
- Ideal for thick, multi-pass protective coatings.
- Non-magnetic, readily machinable deposit.
- Good corrosion resistance.

Recommendation:

Versatile austenitic chromium nickel manganese alloy for intermediate layers and rebuilding before hard surfacing on heat treatable alloy steels and 14% manganese steel. Also recommended for joining thick section parts of dissimilar steels.

Procedure:

After striking, maintain the wire stick-out around 50 mm with an arc length approx. 7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use drag stringer bead or moderate weaving techniques to minimise overheating risks. Stop welding by rapidly lifting the torch away from the work piece.

Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
1.6	26-29	170-240	25-35
2.0	26-29	200-250	25-35
2.4	28-32	200-300	40-60
2.8	28-32	250-350	45-60

Hardness:

As Deposited: 85 - 95 HRB (3 layer)
Work Hardened: 25 - 32 HRC (3 layer)