



Hammer

## Self-shielded open arc flux cored wire with excellent resistance to abrasion and moderate to heavy impact.

### Typical Applications:

For wear protective coatings of screw conveyors, clay crusher cylinders, conveyor chains, waste disposal crusher hammers, crusher bars, tractor rollers and idlers etc.

### Outstanding Features:

- Good combined resistance to abrasion, pressure and impact.
- High resistance to plastic deformation.
- Multipass capability (2-3 layers max.)
- Negligible slag residues.
- Deposits are grindable and corrosion resistant.

### Recommendation:

Medium chromium-carbon self shielded flux-cored alloy useful for wear-protective coating applications. The weld metal achieves good resistance to abrasion, pressure and

moderate impact conditions. Ideal choice for fieldwork or on-site applications.

### Procedure:

Clean the weld area. Remove worn and fatigued metal with EWAC GOUGETRO. Pre-heat if required. Allow natural cooling.

### Welding Parameters:

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

**Hardness:** 45 - 55 HRC (2 layer)