



Mixer Blade

## Open arc self shielded continuous wire designed to withstand abrasion and moderate impact.

### Typical Applications:

Crusher parts, conveyor screws, mantles, mill guides, agitators, mixer blades, dozer blades, bucket teeth, mill hammers.

### Outstanding Features:

- High abrasion resistance with good compressive strength.
- High 'as-deposited' hardness.
- Deposits acquire high polish in service, reduce friction.

### Recommendation:

A special flux-cored, self-shielded, continuous electrode with excellent arc stability and high deposition rate. The weld metal is a highly wear-resistant chromium-carbide type alloy, which effectively withstands abrasion, corrosion and moderate impact.

### Procedure:

Clean the weld area. Remove worn and fatigued metal. Pre-heat if required. Use EWAC O 501 for cushion layer followed by hardfacing with EWAC O 511. Run stringer beads or 2 X weave pattern. Back-whip craters. Clean slag residues with wire brush but do not peen deposit. Allow natural cooling. Finish by grinding.

### Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
2.4	28-32	200- 300	40-60

**Hardness:** 50 - 60 HRC (3 layer)