



Idler

**Open arc self-shielded continuous wire for anti-spalling deposit with excellent cushioning, good impact resistance and high compressive strength.**

#### **Typical Applications:**

For rebuilding and reclamation of chain guide rolls, worn parts on bulldozers, rebuilding of large, severely worn parts.

#### **Outstanding Features:**

- Good resistance to compression and plastic deformation.
- Multi-pass deposit capability.
- Easy slag removal.
- Dense magnetic deposit.
- Readily machinable with cutting tools.

#### **Recommendation:**

Special, self-shielded, flux cored alloy wire specifically developed for outdoor maintenance and repair welding of thick, heavy components where faster weld deposition rates over traditional coated electrodes, are required.

#### **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	26 - 29	170 - 220	25 - 35
2.4	28 - 32	200 - 300	40 - 60
2.8	28 - 32	250 - 350	45 - 60

**Hardness:** 25 - 35 HRC (3 layer)