

**Boom**

Open arc self-shield flux cored wire for joining and build up applications.

Typical Applications:

Joining of crane jibs, truck chassis & heavy equipments.

Outstanding Features:

- Excellent impact resistance and good compressive strength even at low temperature.
- Very good tensile strength and yield strength.
- Smooth operating characteristics with easy slag removal.
- Very good crack-resistance.

Recommendation:

A high performance, flux-cored, self-shielded continuous electrode with excellent arc stability and high deposition rate, designed for joining of low carbon steels & low alloy steels. The deposit exhibits good impact resistance.

Procedure:

Clean the weld area. Remove worn and fatigued metal with EWAC GOUGETRO. Preheat if required. Skip weld to minimise heat build-up. Chip slag & remove residues with wire brush between passes. Allow natural cooling.

Welding Parameters:

Size (mm)	Voltage	Amperage	Stick Out (mm)
1.2	23 - 27	130 - 180	20 - 30
1.6	26 - 29	170 - 240	25 - 35

Tensile Strength: 49 Kg/mm²
(69,000 psi)