



Tip Casting Plate

Open arc self-shield flux cored wire with excellent resistance to serve abrasion and erosion at elevated temperature.

Typical Applications:

Steel components subject to severe abrasion and/or erosion by mineral particles, sand, rocks, coal/coke etc. Other applications include wear protection of pneumatic conveyor systems, mixer blades, pump impellers, excavator bucket teeth, conveyor chutes, concrete mixers, asphalt handling etc.

Outstanding Features:

- Deposits having high hardness.
- Formation of stress relieving cracks to minimise distortion.
- Slag free deposits.
- Smooth, flat, grindable deposits.
- Resistant to flame cutting – use plasma arc process.
- Excellent resistance to abrasion and erosion up to 450°C.

Recommendation:

Self-shielded, flux cored alloy wire for wear protective coating of carbon steels, low or high carbon steels and

14 % manganese steels. Recommended for maintenance and repair welding of thick, heavy components where faster weld deposition rates are required. This wire can be used either manually, semi-automatic or fully automatic to increase productivity.

Procedure:

After striking, maintain the appropriate wire stick-out as specified. 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)
2.40	26 - 30	250 - 300	30 - 40
2.80	28 - 32	260 - 350	35 - 45

Hardness: 60 - 68 HRC

(3 layer hardness)