

**Shrouder Welding**

Open arc flux cored continues wire for joining and overlaying applications.

Typical Applications:

Joining of crane jibs, truck chassis & heavy equipment maintenance.

Outstanding Features:

- Smooth operating characteristics with easy slag removal.
- Dense, bright, well-rippled weld beads with freedom from cracks.
- High impact resistance, with good compressive strength.
- Excellent crack resistance.

Recommendation:

A high performance, flux-cored, self-shielded continues electrode with excellent arc stability and high deposition rate. Designed for joining of low carbon steels & low alloy steels. The weld metal is a proven impact-resistant alloy.

Procedure:

Clean the weld area. Remove worn and fatigued metal with EWAC GOUGETRO. Pre-heat 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)
1.6	26-29	170-240	25-35
2.4	28-32	200-300	40-60
2.8	28-32	250-300	50-70

Hardness: 85 - 90 HRB

Tensile Strength: 52 Kg/mm²
(73,000 psi)