EWACTRO BU 100 ac/dc+

Crusher Rolls

Rapid work hardenable alloy with superior anti-impact property coupled with pressure and abrasion.

Typical Applications:

Track rollers, hydraulic turbines, crusher hammers, overhead gantry tracks, drive sprocket wheels, conveyor rolls, points & crossing, cushion layer applications prior to final hardfacing.

Outstanding Features:

- High 'as-deposited' hardness.
- Work-hardens rapidly in service.
- Excellent crack resistance by absorption of internal stresses.
- Excellent ac / dc weldability and handling features.

Recommendation:

A new high chrome-manganese alloy electrode for wear protection of carbon steels, alloy steels, etc. Also ideal as cushion layer. Weld metal displays high 'as-deposited' hardness which increases further on work-hardening. Deposits are machinable with carbide cutting tools.

Procedure:

Clean weld area. Remove worn and fatigued metal. Use of EWAC GOUGETRO recommended. For medium carbon steels preheat upto 300°C, depending on carbon equivalent and section thickness. Do not preheat austenitic manganese steels and temperature should not exceed 150°C during welding. Using short arc and electrode tilted 10° in direction of travel, deposit stringer beads. Remove slag between passes and peen deposits.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	130 - 160	100 - 130
4.00	150 - 180	120 - 150

Hardness:

As deposited 20 - 24 HRC
Work hardened 35 - 48 HRC

Tensile Strength: 87 Kg/mm^2