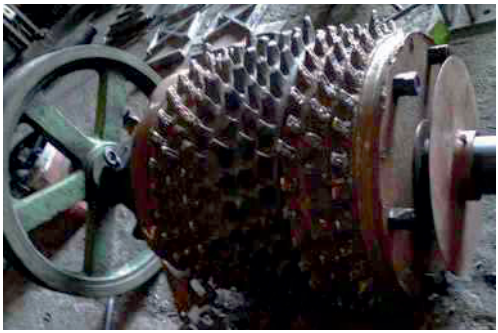
EWACTRO BU 800 ac/dc+



Coal Crusher

An unique electrode having excellent impact resistance deposit with work hardening property.

Typical Applications:

Crusher hammers, wobblers, frogs, sprockets, bucket teeth, wear parts, shovel track pads, under carriage components, scraper blades.

Outstanding Features:

- Tough overlay on manganese steel and alloy steel.
- For severe impact, shock and hammering applications.
- Cold arc coating for lowest possible amperage.
- Work hardens in service.

Recommendation:

A ferrous base electrode with additions of Ni, Mn & other elements to improve welding properties. Ideal Cushion layer before hardfacing on Mn steel, low carbon steel, low alloy steel.

Procedure:

Clean weld area. Use EWAC GOUGETRO to remove damaged metal parts. Do not preheat manganese steels. Maintain a short to medium arc length. On Manganese steel keep bead length 75-100 mm at a time. Inter-pass temperature should be maintained below 150°C for manganese steel by following back-step technique. Skip welding is recommended on large parts. Peening while hot reduces residual stresses. Cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	120 – 140	100 - 120
4.00	160 – 190	130 – 140
5.00	180 – 200	160 - 190

Hardness:

As deposited 90-95 HRB

Work hardened 35-40 HRC