



**Bucket Hardfacing**

## **An advanced electrode for applications exposed to abrasive wear.**

### **Typical Applications:**

Buckets, shovels, excavating equipment, tampers, scrapers.

### **Outstanding Features:**

- Dense and spatter-free deposit.
- Resists high abrasion.
- Rapid deposition.
- All position.

### **Recommendation:**

For weld protective coating subject to abrasive wear and moderate impact. For use on steel, manganese steel and malleable iron. Ideal for both new or worn parts, especially for multi-pass build-ups. All position weldability.

### **Procedure:**

Clean weld area. Use EWAC GOUGETRO to remove contaminated, fatigued and damaged metal. Preheat heavy sections to about 200° - 250°C. Use stringer or weaving technique holding a short to medium arc. Long deposits may be made without danger of cracking. Do not allow excessive heat build-up. Chip slag between passes and allow to cool.

### **Recommended Amperages :**

<b>Size (mm)</b>	<b>I - Range</b>	<b>II - Range</b>
3.15	95 - 100	85 - 95
4.00	125 - 150	90 - 115
5.00	175 - 200	140 - 165

**Hardness:** 57 - 62 HRC (3 layer)