



Crusher Blow Bar

Open arc self-shielded flux cored wire with excellent resistance to impact and work hardening capability

Typical Applications:

For buttering layers prior to hard overlays and wear-preventive coating of crane rollers, crusher cylinders, shovel buckets, mobile crane rails, rail points, coupling of rolling mill extensions, shovel teeth.

Outstanding Features:

- Maximum resistance to heavy impact and compression.
- High resistance to cracking and plastic deformation.
- Rapid work hardening characteristics.
- Easy slag removal.
- Low metal to metal friction coefficient.
- Maximum service temperature 300°C.

Recommendation :

Special, self shielded, flux cored alloy wire specifically developed for

outdoor maintenance and repair welding of thick, heavy components where faster weld deposition rates over traditional coated electrodes, are required.

Procedure:

Clean the weld area. Remove worn and fatigued metal with Eutec-ChamferTrobe. pre-heat if required. Skip weld to minimize heat build-up on Mn steel. Clean slag with wire brush but do not peen deposit. Allow natural cooling.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
1.6	23-27	130-180	25-35
2.8	26-29	250-350	40-60

Hardness:

As Deposited: 90 HRb (3 layer)
Work Hardened: 42 HRC (3 layer)