



Stacker Wheel

Open arc self-shielded flux cored wire for high strength similar and dissimilar joining of low, medium carbon and low alloy steels

Typical Applications:

For repair and joining applications on “difficult” steels, low and high alloy steels and manganese steels. Also, suitable for use as intermediate or cushion layers below wear resistant weld overlay.

Outstanding Features:

- Deposits with superior toughness, crack resistance and impact resistance.
- High alloy deposit gives exceptional mechanical strength and corrosion resistance.
- High deposition rate.
- Easily machinable deposits.

Recommendation:

A high performance, flux-cored, self-shielded continuous electrode with exceptional mechanical properties and high deposition speed. Ideal choice for fieldwork or on site applications.

Procedure:

Clean the weld area. Remove worn and fatigued metal with Eutec-ChamferTrode. Deposit stringer beads or use 2X weave pattern. Back-whip to fill up craters. Remove slag between passers.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
1.2	23-27	130-180	25-35
1.6	26-29	170-240	25-35

Tensile Strength: 65 Kg/mm²
(92,000 psi)