



DE-Bricking Tool

Open arc self-shield flux cored wire with outstanding abrasive wear resistance even at elevated temperatures

Typical Applications:

Sinter handling equipment, coke pusher shoes, clinker conveyer chains, hot slag conveyers, billet conveyer guide.

Outstanding Features:

- Smooth operating characteristics with negligible slag.
- Dense, fine rippled weld beads with multi-pass capability.
- High deposition rate & metal recovery.
- Excellent resistance to Abrasion & Erosion at 650°C.

Recommendation :

A high performance, flux-cored, self-shielded continuous electrode for automatic / semi automatic hardfacing of carbon steels, low alloy steels & austenitic manganese steels. The weld metal alloy containing complex carbides effectively withstands abrasion, erosion and corrosion at elevated temperatures.

Procedure:

Clean the weld area. Remove worn and fatigued metal with Eutec-ChamferTrode. Preheat if required. Use OA 510 for buffer layer or for build-up. Run stringer beads or 2X weave pattern. Back-whip craters. Clean slag residues with wire brush. Do not peen deposit. Allow natural cooling. Finish by grinding.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
1.6	26-29	170-240	25-35
2.4	28-32	200-300	40-60
2.8	28-32	250-350	50-70

Hardness: 58 - 64 HRC (3 layer)