



Quenching Screw

Open arc self-shielded flux cored wire for wear-facing against abrasion and impact

Typical Applications:

For multi-pass intermediate layers and anti-wear coating on roller press rolls, crushers, tie tamping tools, cane knives, shredders, shovel buckets, augers & scraper blades etc.

Outstanding Features:

- High resistance to impact, pressure & abrasion.
- Ideal for thick, multi-pass, protective coatings.
- Finely dispersed titanium carbides in tool steel type weld microstructure.

Recommendation:

Unique martensitic Fe-Ti-Cr-C alloy for repairing of components subjected to high impact combined with severe pressure and abrasion in service.

Procedure:

After striking arc, weld with recommended electrical stick-out. For optimum deposit quality use stringer bead or moderate weaving technique. Break arc by rapidly lifting the torch away from the work piece.

Welding Parameters:

Size (mm)	Voltage	Amperage	StickOut (mm)
1.6	27-30	170-220	20-30
2.8	28-32	260-340	50-65

Hardness: 52 - 58 HRC