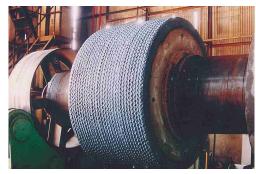
## EWAC O 630





**Roller Press Roll** 

# Open arc self-shielded flux cored wire for severe wear by fine particle abrasion or erosion under moderate impact

#### **Typical Applications:**

For wear protection of steel components in brick and tile, quarry and dredging industry : pug mill augers and segments, press screw heads, humidifier paddles and segments, mixer blades and scrapers, trencher teeth, draught fans, catchment pumps, drag chains, wear plates, press screws, conveyors etc.

#### **Outstanding Features:**

- Properties obtained with single pass.
- Very high hardness achieved on ferritic steels.
- Deposit totally free from slag and no intermediate layers required.
- Good weldability and high deposition rate.

### **Recommendation:**

Proprietary alloy steel formulation depositing extra hard constituents

dispersed in a tough matrix, giving excellent resistance to severe wear by fine particle abrasion or erosion under moderate impact conditions.

#### Welding Procedure:

Clean weld area. Remove fatigued & worn metal. Pre-heat if required. Mn steel (12 - 14%) should be welded in cold condition and the temperature should not exceed 200°C. Avoid excessive heating of the base material.

#### 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	45-60

Hardness: 62 - 67 HRc (2 layer)