



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)