



Crane Wheel

Open arc self-shielded flux cored continuous wire for impact and compressive load applications

Typical Applications :

For rebuilding and reclamation of chain guide rolls, worn parts on bulldozers, rebuilding of large, severely worn parts.

Outstanding Features:

- Good resistance to compression and plastic deformation.
- Multi-pass deposit capability.
- Easy slag removal.
- Dense, magnetic deposit.
- Readily machinable with cutting tools.

Recommendation:

Special, self shielded, flux cored alloy wire specifically developed for outdoor maintenance and repair welding of thick, heavy components where faster weld deposition rates over traditional coated electrodes, are required.

Procedure:

Clean the weld area. Remove worn and fatigued metal with Eutec-ChamferTrode. Pre-heat if required. Allow natural cooling.

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: 25 to 35 HRc (3 layer)