

TeroMatec 0A 3952

Self-Shielded Continuous Electrode For Semi-Automatic And Robotic Welding

DESCRIPTION

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. Worn or new critical parts may be cost effectively TeroCote protected either manually or fully automatically to extend their useful service life and increase productivity and profitability. Complex carbides alloy containing chromium, molybdenum and niobium giving deposits with very high concentration of ultra-hard, primary and eutectic phases to produce maximum resistance to fine, hot particle abrasion and erosion by coke, clinker, cement or sand at elevated temperatures.

- Exceptional resistance to hot abrasion up to 650.C.
- Smooth deposits without machining.
- Very hard deposits with one or two layers maximum.
- Automatic formation of stress relief cracks
- Deposits can be grinded and resist rusting.
- Ideal choice for field work or on site applications
- No need for costly gas cylinders, regulators or flow meters
- Relatively thick, wide overlays possible in single pass
- No enforced stop -starts increase welding duty cycles.
- Variable electrode stick out capability improves control over heat input, dilution, deposition rate, visibility and access in tight spaces.

APPLICATIONS

For use on steel, alloy steel and 12-14% Mn steel parts.

Clinker, sinter crushers. Cement exhaust fan blades.

Blast furnace bells and hoppers.

Hot screens, wear plates, mold extruders

Sinter crushers and fans, hot sieves, screens and bells.

PROCEDURE FOR USE

Preparation: Remove any previous weld deposits or cracked metal with ExoTrod.

Preheating: depends on the steel's Carbon Equivalent, and the workpiece size, thickness and geometry. Castolin Eutectic recommends:

CE < 0.2 : preheat not essential

CE 0.4-0.2 : preheat 200-100.C

CE 0.8-0.4 : preheat 350-200.C.

Note that 12-14% Mn steels should never be preheated and the workpiece temperature during welding should be kept below 250° C.

Intermediate layer: On 12-14% Mn steels, deposit intermediate layers with TeroMatec 3205 or with the manual electrode Eutectrode 6450.

On hardenable and air-hardening steels, deposit intermediate layers with TeroMatec 3302 or XHD646.

Welding parameters: Welding current: = (+)

TECHNICAL DATA

Typical hardness: 65 HRC

Current polarity: DC (+)

Electrode(mm)	Voltage (V)	Current (A)
1.6mm	26-33	100-240
2.8mm	26-36	250-440