



**SUPERON OA FLUX CORED HARDFACING WIRES
&
JOB WORK REPAIR SERVICES**

“World Class Products”



Self shielded open arc continuous wire with high resistance to impact and compression, suitable for joining and hard surfacing.

Outstanding Features :

- Deposits work hardens in service.
- Fully austenitic weld deposit makes it ideal for joining & hard surfacing.
- Deposits can take good impact.
- Deposits are spalling & galling resistant.
- Can be used for Mn steel to carbon steel joining.
- Excellent crack resistivity.
- Ideal for thick, multipass protective surfacing.



Typical Applications :

Heavy earth moving equipment's and shovels, dozer blades, impactor arms, impactor, wobblers hammers, crushers. Can also be used on forged/ alloyed sprockets, crusher mantle, coke crushers etc.

Recommendations:

Cr-Ni-Mn based austenitic deposit, exhibiting work hardening characteristics along with good strength and corrosion resistance. Deposits have low coefficient of friction and can polish under service. Versatile alloy for intermediate layers and rebuilding before hard surfacing on heat treatable alloy steel and 14 % Mn steels. Also recommended for joining thick section parts of dissimilar steels.

Procedure:

Clean the weld area. Remove fatigued metal with Super Stangouge. After striking the arc, maintain the wire stick out as prescribed with an arc length approx. 6-7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use stringer bead or moderate weaving. Stop welding by rapidly lifting the torch away from the work piece.

Hardness:

As deposited : 180 – 200 BHN.
After work – hardened : 400 BHN.

Welding Parameters:

Size Ø(mm)	Voltage	Amperage	Stick Out(mm)
2.4	25 – 27	260 – 300	30 - 40
2.8	26 – 28	300 – 340	35 - 45

Standard Pack:

12.5 Kg Spool

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

Outstanding Features :

- Rich chemistry of C–Cr–Mo alloyed flux-cored wire.
- Excellent resistance to abrasion, erosion and medium impact.
- Negligible slag.
- Deposits can take temperature up to 450°C.
- Properties obtained on the first pass or layer.
- Good weldability and high deposition rates.
- Deposits are grind finishable.



Typical Applications :

Pulverising roller segments & tyre segments of coal, limestone & clinkers mills. For wear protection of steel components in brick and tile, quarry and dredging industry. Pug mill augers, screws, humidifier blades and scrapers, draft fans, drag chains, press screws and conveyors etc.

Recommendations:

Innovative alloy steel formulation depositing extra hard constituents dispersed in tough matrix, giving excellent resistance to wear by fine particle abrasion or erosion under moderate impact conditions at higher temperatures also. For heavier build ups it is suggested to use Super Stanhard OA 40 as a base/ build up layer. Best suited alloy for automation of deposition.

Procedure:

Clean the weld area. Remove fatigued metal with Super Stangouge. After striking the arc, maintain the wire stick out as prescribed with an arc length approx. 6-7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use stringer bead or moderate weaving. Stop welding by rapidly lifting the torch away from the work piece.

Hardness:

57 – 60 HRc.

Welding Parameters:

Size \varnothing (mm)	Voltage	Amperage	Stick Out (mm)
2.4	27 – 30	260 – 300	30 - 40
2.8	28 – 31	300 – 340	35 - 45

Standard Pack:

12.5 Kg Spool

Open arc self-shielded flux cored wire for severe abrasion, corrosion, combined with moderate impact .

Outstanding Features :

- A chromium carbide rich deposit.
- Excellent resistance to severe abrasion, corrosion combined with moderate impact.
- Negligible slag.
- High as deposited hardness.
- Deposits acquire high polish in service and reduces friction.
- Good weldability and high deposition rates.
- Deposits are grind finishable.



Typical Applications :

Crusher parts, conveyor screws, mantles, mill guides, agitators, mixer blades, dozer blades, bucket teeth, mill hammer etc.

Recommendations:

A special flux cored, self-shielded, continuous wire with excellent arc stability and high deposition rates. The weld metal is a highly wear resistant chromium carbide type alloy, which effectively with stands severe abrasion, corrosion combined with moderate impact..

Procedure:

Clean the weld area. Remove fatigued metal with Super Stangouge. After striking the arc, maintain the wire stick our as prescribed with an arc length approx. 6-7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use stringer bead or moderate weaving. Stop welding by rapidly lifting the torch away from the work piece.

Hardness:

55 – 58 HRc.

Welding Parameters:

Size \varnothing (mm)	Voltage	Amperage	Stick Out (mm)
2.4	27 – 30	260 – 300	30 - 40
2.8	28 – 31	300 – 340	35 - 45

Standard Pack:

12.5 Kg Spool

Open arc self shielded flux cored with excellent resistance to grinding abrasion and moderate impact.

Outstanding Features :

- Complex carbide rich abrasion resistant deposits.
- Slag free deposits.
- Very high hardness achieved on single layer
- Deposits are smooth, flat & grind finishable.
- Excellent weldability and deposition rates.



Typical Applications :

Exhaust fans, earth-moving applications like, buckets, track pads, lip plates, teeth points, scrapers, dozers blades etc. For anti-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, fan blade, catchments pumps drag chains, wear plates, press screws, conveyors etc.

Recommendations:

Complex Carbide self shielded flux cored alloy useful for wear surfacing applications. The weld metal gives good resistance to grinding abrasion, pressure and moderate impact in service. Ideal choice for earth moving applications. For heavier buildup it is suggested to use Super Stanhard OA 40 in the base layers.

Procedure:

Clean the weld area. Remove fatigued metal with Super Stangouge. After striking the arc, maintain the wire stick out as prescribed with an arc length approx. 6-7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use stringer bead or moderate weaving. Stop welding by rapidly lifting the torch away from the work piece.

Hardness:

62-65 HRc.

Welding Parameters:

Size Ø (mm)	Voltage	Amperage	Stick Out (mm)
2.4	27 – 30	260 – 300	30 - 40
2.8	28 – 31	300 – 340	35 - 45

Standard Pack:

12.5 Kg Spool

Open arc self-shielded flux cored wire with high complex carbides for severe abrasive & erosive wear at elevated temperatures.

Outstanding Features :

- Single pass deposit gives best intrinsic properties.
- Smooth operating characteristic with slag free deposits.
- Deposits are smooth, hard & flat requiring less finishing
- Best in class resistance to severe erosion, abrasion combined with elevated temperatures.
- Deposits withstand temperature to a maximum of 650°C.



Typical Applications :

Sinter handling equipment's, sinter star, knife bars, coke pusher shoes, clinker conveyor chains, hot slag buckets, augers, clinker breaker hammers, blast furnace bells, etc....

Recommendations:

C-Cr-B-W-V rich alloy system giving the best in class abrasion, erosion at elevated temperatures. A self shielded flux-cored alloy useful for wear surfacing applications. The weld metal gives good resistance to severe abrasion, erosion combined with elevated temperatures. Ideal for wear protection of manganese based steels, high alloy steels & carbon steels. For heavier buildup it is suggested to use Super Stanhard OA 40 in the base layers.

Procedure:

Clean the weld area. Remove fatigued metal with Super Stangouge. After striking the arc, maintain the wire stick out as prescribed with an arc length approx. 6-7 mm. Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use stringer bead or moderate weaving. Stop welding by rapidly lifting the torch away from the work piece.

Hardness:

63-65 HRc.

Welding Parameters:

Size \varnothing (mm)	Voltage	Amperage	Stick Out (mm)
2.4	27 – 30	260 – 300	30 - 40
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Standard Pack:

12.5 Kg Spool

I. Cement Sector

- ★ Coal Mill/Raw Mill Tyres & Table liners.
- ★ Hammers :(both Primary and Secondary) also raw mill Hammers.
- ★ Impactors.
- ★ Jaw Crushers.
- ★ Blow Bars.
- ★ Disc Rollers.
- ★ Sprockeks (also for captive mining units)
- ★ Idler Rollers (also for captive mining units)
- ★ Re-blading of PA /FD etc type.

II. Steel Plants

- ★ Crushing wheels for sintering mills.
- ★ Feed roll.
- ★ Plough feeder.
- ★ Re-blading of industrial fan blades.

III. Power Plants

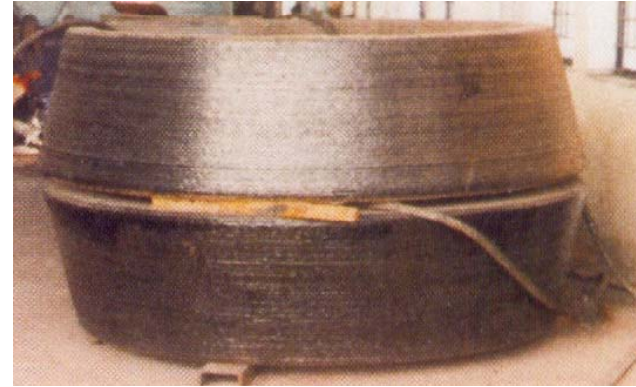
- ★ Coal mill tyres and liners.
- ★ Coal crusher rolls (both L&T /Sayaji make).
- ★ Re-blading of industrial fan blades.

IV. Mining

- ★ Bradly mill rolls.
- ★ Crusher rotors.

- ★ Hammers :(both Primary and Secondary) also raw mill Hammers.
- ★ Impactors.
- ★ Jaw Crushers.
- ★ Blow Bars.
- ★ Disc Rollers.
- ★ Sprockeks.
- ★ Idler Rollers.
- ★ Kiln suppot tyre /roller.
- ★ Trunion crack reparing (Mostly in cement plants).
- ★ Wagon tipler (in CHP of power plants).
- ★ Coal crusher.
- ★ Re-blading of fan blades (dynamic balancing is not going to be in our scope of work).
- ★ Bucket repair of various capacities in mining units (PC, Drag line, Shovel etc).Bradly mill rolls.

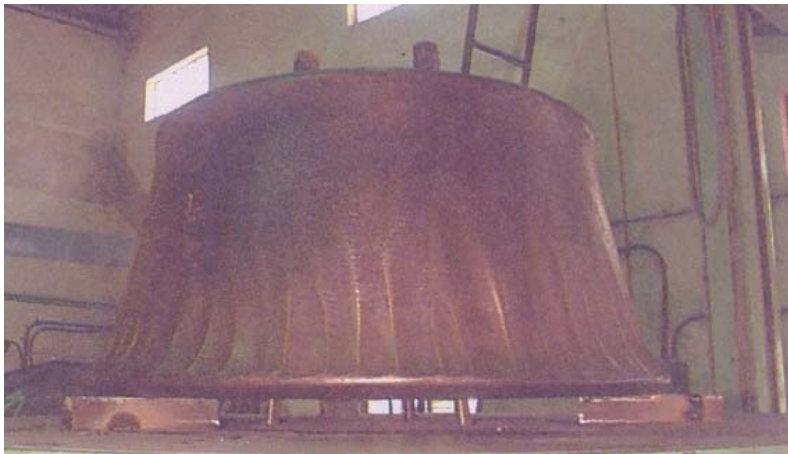
Cement Plant VRM Tyre and Liners



Tyre

Liners

Power Plant Coal Mill Rolls



Worn Out Roll



Rebuild Roll

Complete Refurbishment of Fan Blades of Raw Mill



SUPERON[®] Different Types of Crushing Equipments



Crushing Wheels for Sintering Mills of Steel Plant

