

Roller Arc



SUMMARY

- > Self Shielded Hard Surfacing Flux Cored Wire
- > Copper Coated for Improved Current Transfer
- > Unique Seamless Construction For Superior Wire Feeding
- > Tough, Wear Resistant, High Chromium Austenitic Iron Deposit
- > Ideal for the Semi or Fully Automatic Surfacing of Sugar Mill Rolls

CLASSIFICATION

- > AS/NZS 2576: 2145-B7
- > WIA TECH NOTE 4 2145-B7

DESCRIPTION

Roller Arc is a Trademark protected copper coated flux cored wire primarily for the “open arc” surfacing of cast iron sugar mill rolls. Often used “in situ” during cane crushing, the chromium carbide/austenitic iron deposit of Roller Arc gives mill roll teeth an enhanced gripping action and superior resistance to abrasive wear.

The unique seamless tube construction of Roller Arc allows the wire to be copper coated for enhanced wire feeding and improved current transfer from gun contact tip to wire. This feature of Roller Arc is particularly important for difficult out-of-position applications where long gun cables and awkward gun angles are often unavoidable.

Roller Arc is also suitable for conventional open arc hard surfacing applications where resistance to both heavy abrasion and high impact are required. Such applications include the surfacing of crushing and earthmoving equipment, etc.

The intellectual property of the Roller Arc design is owned and protected by an ITW subsidiary manufacturer in Germany.

STORAGE INFORMATION

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	WELDING CURRENT RANGE (AMPS)	ARC VOLTAGE RANGE (VOLTS)**
2.8	300 - 350	30 - 34

**Voltage is determined by arc current and electrode arc length. Arc voltage shown are typical and are only to be used as a guide.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Si	Ni	Fe
2.05	1.37	13.2	0.90	0.002	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

	NUMBER OF LAYERS	AS-DEPOSITED ON
Hardness	1	44 - 50 HRc
Abrasion Resistance:		Excellent
Impact Resistance:		Good
Non-Machinable:		Grinding Only
Flame Cutting:		Difficult
Deposit will Relief Check Crack		

APPLICATIONS

- > Sugar Mill Roll Roughing
- > Bucket Teeth

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE (KG)	PART NO.
2.8	25kg Coil	RA28C-1

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