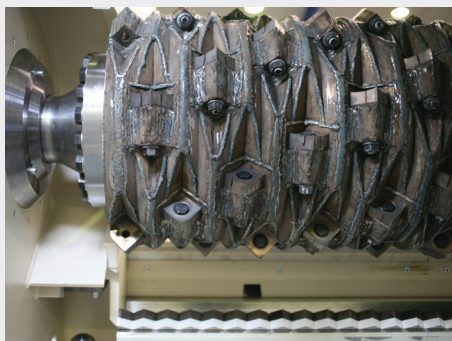


Hardfacing



1. Armored Cutter Holders

Front of cutter holders covered with stringer welds of Lincore 55 only. (Holders are ordered as armored)



2. Peaks and Valleys

Front of cutter holders covered with stringer welds of Lincore 55 and all of the peaks and valleys on the rotor face have a string of Lincore 55 hard face weld. (Holders are ordered as armored)



3. Full Hard Faced

Front of cutter holders covered with stringer welds of Lincore 55 and the rotor wear face is covered 100% with Lincore 55 hard face weld.

Application of Lincore 55

The Lincore 55 hard face weld has a 50 Rockwell value and extends the life of the wear face considerably depending on the product being shredded. During regular maintenance the rotor hard facing should be reapplied at various intervals depending on wear. Lincore 55 can be applied without preheating and can be applied in all welding positions except overhead. The welds can be applied over top of one and other and can be applied using a stringer or weave application. We have found that we have the best results with 75/25 gas (75% Argon 25% C02). If the rotor is left without maintenance and the hard face wears off and the base steel wears, the rotor can be built up with ER70S mig wire with 75/25 gas or 7018 welding rod and then hard face with Lincore 55 over the built up area.

Anti-splatter spray should be applied before welding as the hard face weld will cause a considerable amount of splatter. Extra care should be given to the tops of the cutter holders if the cutters are not installed during the application as the splatter from the welds will be difficult to remove from this area. Leaving an old set of cutters installed is recommended. When applying the hard face to the front edge of the holders it is recommended that a brass insert be fabricated to replace the cutter, this will stop the cutter from being welded to the holder. As with all welding processes you should never ground your part through a bearing. When welding to the rotor the ground clamp should be clamped to the rotor, when welding to the frame of the machine the ground clamp should be clamped to the frame. Failing to follow these instructions can permanently damage the rotor bearings as the rollers in the bearing can arc to the race as amperage passes through it.

Vecoplan, LLC
P.O. Box 7224 • High Point, NC 27264
Phone: 336•861•6070 Fax: 336•861•4329

www.vecoplanllc.com

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www.vecoplanllc.com
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