

XL-CS-31 OA/SA

X'tralife Flux Cored Wire

XL-CS-31 OA/SA is suitable for build up of carbon and low alloy steel parts and a good base for hardfacing. It gives crack free deposits on tractor rollers, idlers, and rails. **Especially suitable for multiple layers.**
Use **UV-A** flux.

APPLICATIONS

Tractor Parts, Crane Wheels, Mine Car Wheels, Table Mill Rolls, Shovel Parts etc

ALLOY CONTENT

C, Mn, Si, Mo

HARDNESS IN HRC

28-30

RECOMMENDED OPERATING PARAMETERS

Diameters (In mm)	2.40	2.80
Current (In Amps)	250-300	300-350
Voltage (V)	26-32	26-32
Stick out (In mm)	30-40	30-40

Power Source: Constant Potential DC+ve

PACKING DATA

Standard wires diameters: 2.40mm, 2.80mm

Supplied in 12.5 Kgs / 15 Kgs layer wound vacuum packed plastic spool or in 125 Kgs / 250 Kgs corrugated drums.

Also available in 1.20mm/1.60mm/2.00mm diameters and other type of packaging on request.

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