WELDING & FORMING GUIDELINES

GUIDELINES FOR SUPER-C® CLADDED WEAR PLATE

Cutting Examples

Plasma arc cutting with conventional arc cutting techniques and gases are recommended for shape cutting, piercing large holes, and beveling.

Grinding

Grinding and EDM methods are the only proven, satisfactory methods for precision removal of metal. When grinding a hard-grit, a soft bond wheel is required. For non-precision metal removal and hole piercing, use carbon arc gouging.

Cold Forming

Generally, the power required to form Super-C™ will be approximately the same as required for low carbon.

Welding

Super-C™ is normally supplied with plasma arc cut edges ready for welding. Welding to carbon steel support structures is accomplished with either Prime-Arc 85™ or Tri-Weld 3™ electrodes using the proper welding procedures. Care should be taken to prevent the clad portion of the plate from diluting the fillet weld.

1-Layer

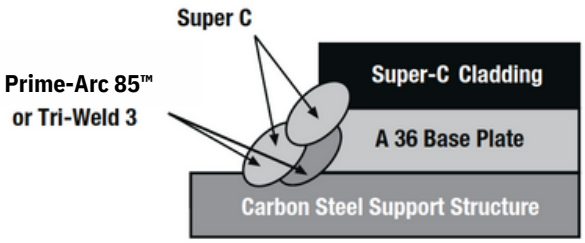
Nominal Thickness		Cladding Thickness*		Base Plate Thickness	
mm	inch	mm	inch	mm	inch
9,53	3/8	4,76	3/16	4,76	3/16
12,70	1/2	6,35	1/4	6,35	1/4
15,88	5/8	6,35	1/4	9,53	3/8
19,05	3/4	6,35	1/4	15,88	5/8
22,23	7/8	6,35	1/4	15,88	5/8
25,40	1	6,35	1/4	19,05	3/4

2-Layer

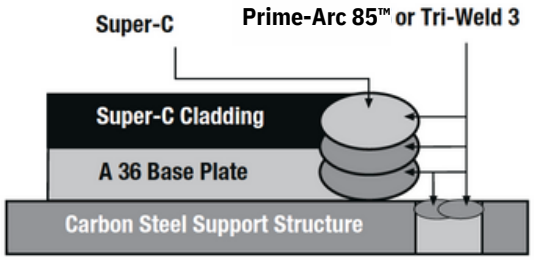
Nominal Thickness		Cladding Thickness*		Base Plate Thickness	
mm	inch	mm	inch	mm	inch
12,70	1/2	7,94	5/16	6,35	1/4
15,88	5/8	9,53	3/8	6,35	1/4
19,05	3/4	9,53	3/8	9,53	3/8
22,23	7/8	9,53	3/8	12,70	1/2
25,40	1	9,53	3/8	15,88	5/8

Examples:

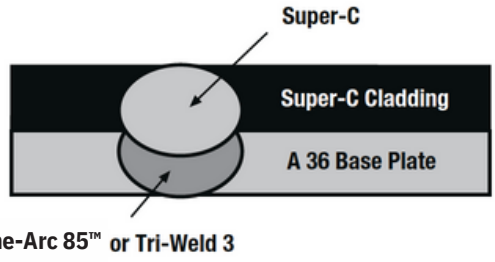
FILLET WELDING



PLUG WELDING



SEAM WELDING



Super-C®