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SUBMERGED-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- martensitic chromium steel;
- excellent resistance to both impact and abrasion;
- can be multi-layered;
- recommended in **applications of metal to metal wear**;
- deposit is machinable with tungsten carbide tools;
- hardfaces mild steel, low alloy steel and manganese steel;
- use of a **neutral flux** is recommended.

MECHANICAL PROPERTIES:

- 42 - 48 RC as deposited

PROCEDURE:

Voltage	28 - 32
Amperage	300 - 450
Optimum	30 - 350
Stick-out	2 - 3"

- DC reversed polarity,
- remove all damaged material;
- avoid localized overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- Ditcher rollers, charging car wheels, idlers, blast furnace bell seats, etc.

OTHER:

- Deposition Rate: 10 -20 lbs./hr.;
- available in diameters of 1/ 8 " , 7/64" , 3/32" , 5/64" , 1/16" & .045";
- packaging: 28 & 10 lb. spools., 55 lb. coils, 100, 250 & 450 lb. pay-off-packs.

