

## MULTI-FUSION 2000

### OPEN-ARC FLUX-CORED HARDFACING WIRE

#### CHARACTERISTICS:

- **multi complex carbide** embedded in a high grade chrome carbide matrix;
- **rivals tungsten carbide** in wear resistance (wet or dry);
- unlike tungsten carbide, **MULTI-FUSION 2000** also **withstands impact**;
- has **out of position** welding capabilities;
- excellent for **multi pass** applications;
- can be overlaid on most base metals including stainless steel using appropriate procedures;
- maintains its hardness up to 1200°F (according to U.S.D.O.E. testing);
- deposit is grindable only.

#### MECHANICAL PROPERTIES:

- weld metal hardness: 63 R.C.
- single pass hardness: 56 – 60 R.C.

#### PROCEDURE:

|           | <u>.045"</u>  | <u>.062"</u> | <u>Large</u>  |
|-----------|---------------|--------------|---------------|
| Voltage   | 18 -30        | 18 - 30      | 26 - 34       |
| Amperage  | 90-180        | 140-280      | 250-500       |
| Optimum   | 24-140        | 24 -210      | 28 -425       |
| Stick-out | 3/4" - 1 1/4" | 3/4" - 2"    | 3/4" - 2 1/4" |

- DC reversed polarity;
- remove all damaged material;
- avoid localised overheating of manganese steel by keeping bulk of part below 550°F;
- crack sensitive material should be preheated to 500-700°F depending on thickness & dimensions; **Avoid thermal shock**;

#### TYPICAL APPLICATIONS:

- All types of crushers, crusher parts, wear plates, impeller blades, screw flights, buckets, shrouds, teeth, adapters, tables, etc.

#### OTHER:

- Deposition rate: 10 - 20 lbs./hr. Relative to wire diameter;
- Available in diameters of 7/64" , 3/32", 5/64", 1/16", & .045"
- Packaging: 10 & 28 lb. spools, 55 lb. coils, 100, 250 & 450 lb. pay-off-packs.