

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.

G-65A ABRASION TEST COMPARISON

MULTI-FUSION 2000 *	TungstenCarbide	HiGradeChromeCarbide	ChromeCarbide
.10 - .14 gr.	.08 - .10 gr.	.18 - .23 gr.	.30 - .45 gr.

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: 55 lbs. coils, 100, 250 & 500 lb. pay-off-packs, 28 lb. and 10 lb. spools.
- **This product is also available in pre-welded wear plate.**

* Samples showed smooth surfaces on all sides with no porosity or inclusions evident. Surface wear scar – smooth, even and shallow with no porosity or inclusions. Surface scar test - .135 grams. After removal of 75% of weld metal, all conditions remained the same with a result of .140 grams. Test sample involved – 2 pass weld with as welded thickness of ¼" prior to surface preparation for testing.

