

## MACROJET

### OPEN-ARC FLUX-CORED REBUILDING WIRE

#### CHARACTERISTICS:

- austenitic chrome - nickel - manganese steel;
- renowned as being amongst the **toughest** and **most impact** resistant wires available on the market;
- sound multi-layer deposits which work harden under load;
- **often eliminates the necessity of hardfacing**;
- ideally suited to **build up and join** 11-14% manganese steel, carbon steel and other alloy steels;
- deposit is machinable before work hardening;
- high resistance to deformation;;
- excellent underbase for abrasion resistant hardfacing such as HA-4 series, HA-5, HA-6, and so on;
- **fantastic slag removal** - revealing a smooth - generous bead of austenitic chrome-nickel-manganese steel;
- transfer is completely **spray mode** and **very fast**.

#### MECHANICAL PROPERTIES:

- 18 - 24 RC as deposited
- 45 - 55 RC work hardened

<u>PROCEDURE:</u>	<u>.045"</u>	<u>1/16"</u>	<u>5/64"</u>	<u>Large</u>
Voltage	24 – 26	26 – 28	26 – 28	28 – 32
Amperage	120-150	180-250	200-300	275-375
Optimum	26 – 140	28 – 190	28 – 260	30 - 350
Stick-out	1" - 2"	1½"- 2½"	1½"- 2½"	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;
- stick-out: 2 - 3"

#### TYPICAL APPLICATIONS:

- crusher parts, wobblers, runners, impellers, wheel excavator teeth, crusher jaws, muller tires, etc.

#### OTHER:

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

