

AMTEC W1061 MC-G HARDSURFACING WIRE

GENERAL CHARACTERISTICS

Amtec W1061 MC-G is a chromium free metal cored hardsurfacing wire. This product has a good balance of abrasion and impact resistance. It is a silicon-boron-columbium carbide product that has a hardness of 56-57 RC with one layer on 1020 steel. The hardness rises on steels with higher carbon content.

PROCEDURE

Use DC Reverse Polarity

.045.....22 – 24 volts, 120 – 200 amps, 1” stick-out
1/16.....24 – 26 volts, 175 – 300 amps, 1.25” stick-out

If a gas cover is used, Argon/CO2 or 100% CO2 is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened. When welding out of position, use the lower range of amperages and voltages. In addition, a gas cover may be useful, especially when using a constant current power source and voltage-sensing feeder.

APPLICATION

This alloy can be used on minimal impact and severe abrasion resistance applications such as earth moving, crushing, and grinding equipment. Specific uses include screw conveyors, scraper blades, fan blades, dredge pumps and impellers.

WELDING PROPERTIES

Wire Type: Metal-Cored, Gas-Shielded Silicon, Boron, Columbium
Hardness: 56 – 57 RC
Deposit Thickness: 2-3 layers recommended
Cannot be Flame Cut
Deposit will not cross check

Standard Packaging: .045 x 25 lb. Spools, 1/16 x 25 lb. Spools.

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