

AMTEC W1068 AP HARDSURFACING WIRE

GENERAL CHARACTERISTICS

Amtec W1068 AP is a general purpose all position hardsurfacing wire. This product has a good balance of abrasion and impact resistance. It can be used for metal to metal wear as well as metal to earth abrasion wear.

PROCEDURE

Use DC Reverse Polarity

.045.....22 – 26 volts, 150 – 250 amps, ½” – ¾” stick-out
1/16.....24 – 28 volts, 175 – 350 amps, ½” – 1” 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 should be used for building up of shafts, idlers and metal to metal wear construction parts, as well as any out of position hardsurfacing on buckets. This product is one of the few wires that a 1/16 size wire can be successfully used out of position.

WELDING PROPERTIES

Wire Type: Flux-Cored, Gas-Shielded Manganese, Silicon, Chromium, Molybdenum.
Hardness: 55 – 58 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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