

**AMTEC W1610 MC HARDSURFACING WIRE**  
**DC REVERSE POLARITY METAL CORED WELDING WIRE**

**General Characteristics**

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Amtec W1610 MC is an extra high carbon, chromium carbide hard overlay that is designed for extreme abrasion and abrasion combined with mild impact. This alloyed hardsurfacing wire can be used on carbon, alloy, manganese, and stainless steels. Amtec W1610 MC may be used without a gas coverage, however with .045 and 1/16 wire, shielding gas is recommended if out of position welding is desired. Shielding gas will cause the amperage to go up by about 10%.

**Procedure**

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Clean the welding zone free from oil, rust and other contaminants. Use DC reverse polarity and Argon CO2 gas or straight CO2 at the following settings:

Size:	.045	1/16	.045	1/16
Amps	100-250	160-300	100-250	160-300
Volts	15-26	20-28	15-26	20-28
Gas	Ar/CO2	Ar/CO2	CO2	CO2
CFH	25-30	25-30	25-30	25-30
Stick-out	1"	1 1/2"	1"	1 1/2"

If welding out of position, we recommend the use of the lower ranges of voltage (16-19) and amperages (100-150). If an external shielding gas is used with short-arc welding, amperages will go up by about 10% and the stick-out should be shortened.

**Application**

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Due to its hardness and wear resistance, Amtec W1610 MC wire is intended as an overlay of items such as scraper blades, road ripper teeth, bucket sides and bottoms, tillage tools, auger flights, and screw conveyors. It is also excellent on mixer blades, slag handling equipment, bucket teeth, fan blades, tamper tools, coal feeder screws, pug mill paddles, grizzly bars and chutes.

**Wire Type:** Metal Cored, open arc or gas-shielded, slag free deposit, hardsurfacing welding wire.

**Hardness (RC)** 58-62 as deposited (2 passes)

**Maximum number of passes:** 2 layers

**Deposits are non-machinable, and cannot be flame cut**

**Deposits will readily cross-check to relieve stresses.**

**Alloy Content:** Carbon, Chromium, Molybdenum, Manganese and Silicon.

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**Standard Packaging and Sizes:** .045 x 25 lb. spools  
1/16 x 25 lb. spools

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**CONFIDENTIAL INFORMATION: Subject to Change without Notice**