



**AMTEC W1060 FCG HARDSURFACING WIRE**  
**DC REVERSE POLARITY FLUX CORED WELDING WIRE**

**General Characteristics**

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Amtec W1060 FCG is a medium-high hardness, flux-cored, economical hardsurfacing, well suited for applications involving abrasion or abrasion combined with moderate to heavy impact. Use on carbon steels, low alloy steels, manganese steels, and stainless steels.

**Procedure**

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

	SHORT ARC		OPEN ARC	
Size:	.045	1/16	.045	1/16
Amps	175-225	225-275	160-200	175-225
Volts	19-21	20-23	21-23	24-26
Gas	Ar/CO2	ArCO2	None	None
CFH	25-30	25-30	n/a	n/a
Stick-out	3/4"	1"	1"	1 1/4"

If welding out of position, we recommend the use of shielding gas, and the lower ranges of voltage (16-19) and amperages (100-150).

**Application**

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For overlaying carbon and low alloy steel, manganese steel and stainless steel, where a combination of abrasion and impact resistance, and good metal to metal wear properties are desired. Use on dredge parts, earth moving, mining, construction and farming equipment. Preheat is generally not necessary unless the parts are cold, then only 250°F is needed.

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**Wire Type:** Flux Cored, gas-shielded or open arc hardsurfacing welding wire.

**Hardness (RC)** 52-56 as deposited (1 pass)

**Hardness (RC)** 53-57 as deposited (2 passes)

**Maximum number of passes:** 2 layers

**Deposits are non-machinable**

**Deposits may cross-check to relieve stresses, especially on higher carbon components.**

**Alloy Content:** Carbon, Chromium, Molybdenum, Vanadium, 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**