



AMTEC W1063 MC HARDSURFACING WIRE

DC REVERSE POLARITY METAL CORED WELDING WIRE

General Characteristics

Amtec W1063 MC is a high hardness hardsurfacing well suited for applications involving high abrasion or abrasion combined with mild impact. Use on carbon steels, alloy steels, manganese steels, stainless steels and cast iron.

Procedure

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		SPRAY ARC	
Size:	.045	1/16	.045	1/16
Amps	100-250	160-300	300-350	350-400
Volts	15-26	20-28	31-33	31-33
Gas	no gas	no gas	Ar/Ox	Ar/Ox
CFH	n/a	n/a	40-45	40-45
Stick-out	3/4"	1"	5/8"	3/4"

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

Due to its hardness and wear resistance, Amtec W1063 MC wire is intended as an overlay of items such as cultivator sweeps, bag packer screws, cement chutes, induced draft fans, feeder screws, brick augers and mixer paddles. It is also good for hardsurfacing bulldozer blades, grader blades, paving machine screw conveyors, coal chutes, shovel buckets, bucket teeth, and undercutter bits.

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

Hardness (RC) 60-65 as deposited (2 passes)

Maximum number of passes: 2 layers

Good Hot-Hardness up to 1100°F

Deposits are non-machinable

Deposits will cross-check to relieve stresses.

Alloy Content: Carbon, Chromium, Molybdenum, Boron, Vanadium, Manganese and Silicon.

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

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