



**AMTEC W1067 MC HARDSURFACING WIRE**  
**DC REVERSE POLARITY METAL CORED WELDING WIRE**

**General Characteristics**

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Amtec W1067 MC hardsurfacing wire is a general purpose hard overlay with good abrasion resistance and excellent toughness. The all weld metal properties are similar to H-13 tool steel. Deposits will retain their hardness up to 1100°F and will maintain a good cutting edge.

**Procedure**

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

	SHORT ARC		SPRAY ARC	
Size:	.045	1/16	.045	1/16
Amps	90-200	150-220	250-325	300-375
Volts	15-21	18-21	27-30	27-30
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox
CFH	25-30	25-30	40-45	40-45
Stick-out	1/2"	3/4"	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).

**Application**

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Due to its hardness and wear resistance, Amtec W1067 MC wire is intended as a build-up and final overlay for hot shear blades, forging dies, and gripper dies. It is also excellent on earth abrasion applications such as tillage tools, dozer blades, bucket teeth, augers, and other moderate abrasion or heavy impact applications.

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**Wire Type:** Metal Cored, gas-shielded, slag free deposit, hard overlay welding wire.

**Hardness (RC)** 55-59 as deposited

**Maximum number of passes:** 2-3 layers

**Deposits are non-machinable, but may be flame cut.**

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

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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**