

Elite-performance, Long-Life wire for ground-engaging equipment

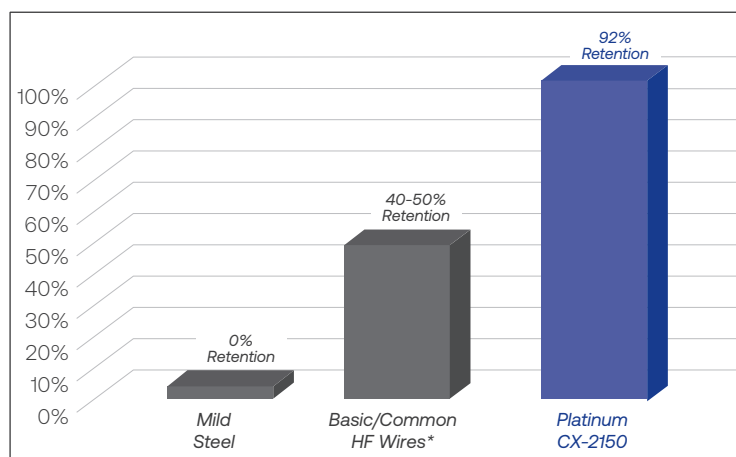
- Unique combination of extreme abrasion resistance AND high impact strength (unlike most “abrasion” wires which tend to have low impact resistance)
- Ultra-high-performance long-life wire for ground-engaging & similar equipment
- Ideal for all abrasion applications
- Especially suitable where abrasion is the primary cause of wear, but the tools/ implement may be exposed to heavy impact (which may cause lower-impact hardfacing products to chip or break off)
- Easy to use: Smoother arc at low amperage vs other wires
- Gasless wire for easy application in the field or workshop
- Suitable for use with MIG welders 200 Amps & above

Typical Applications Include:

- Agricultural & earthmoving
- Ground engaging machinery
- Points and tynes
- Screws & Augurs
- Bucket lips & teeth
- Grousers
- Harvesting & Cutting equipment



Wear Comparison



Reduce costs, Increase service-life:

- 7-8 times better wear life vs common/basic hardfacing wires*
- More Uptime: Longer equipment service life
- Less Downtime: fewer equipment service shut-downs
- Reduced Cost: Less frequent hardfacing applications = lower wire usage



*Basic solid and flux-cored hardfacing wires with Cr content of <10%

Comparisons shown are approximate typical values, for indicative comparison purposes only. Actual performance will vary from product to product and application to application. Trials should be conducted to determine how a specific wire will perform in any given application/situation.



Ordering Information

Wire Size	Spool Size	Part No
1.6mm	12.5kg 200mm	WC-03791

Note: To incorporate the 'ingredients' that allow this wire to offer ultra-high performance, it can only be manufactured in 1.6mm & is not available in 1.2mm.

As per details below, this wire only requires a maximum of 240 amps.



Technical Data

PROPERTIES

Description	Hard-facing, flux-cored tubular gasless (open-arc) welding wire						
Classifications*	AS/NZS 2576:2360-B7						
Typical Analysis (%) of all-weld metal	Element	C	Si	Mn	Cr	Proprietary	Fe
	%	4.5	1.75	<1	25	++	Bal.
Typical Hardness	~60-30 HRC (Rockwell). Max hardness achieved with 2 layers.						

APPLICATION

Recommended For	Metal-to-earth applications requiring exceptional abrasion resistance with heavy impact resistance
NOT Suitable For	Not recommended for equipment that will be submerged in salt-water

PREPARATION

Surface Prep	IMPORTANT: Surface to be hard faced must be clean and free of rust, scale, grease, moisture & other contamination. If existing/old hardfacing deposits are loose they should be removed. (Hammer test can confirm bond strength of existing deposits, a "ping" indicates good bond and a "clack" indicates a separation layer which must be ground off).
Buffer Layer / Pre-Heat	Will typically weld easily to most common surfaces without the need for buffer layer or pre-heat. If applying to hard-to-weld steels, or hard-to-weld existing deposits, use buffer layer of 309 or 312 wire or electrodes. Whilst not essential, pre-heat of 150-350oc may be beneficial. If applying to high-manganese (non-magnetic) steel, buffer of high-Mn/Cr specialist wire should be used.

OPERATING DATA

Shielding Gas	Not required. Gasless wire by design but additional shielding gas can be used if desired.
Polarity	DC+ (Wire/torch positive, Earth negative)
Typical Parameters	1.6mm: 160-240A / 20-26V IMPORTANT: Avoid overheating. Amperage & voltage should be as low as possible within the recommended range. Applying excessive heat/voltage will reduce the performance and wear life of the weld deposit.
Positions	Flat "downhand" position only (not suitable for vertical or overhead)
Multi-layer	Up to 3 layers. Best results are usually achieved with 2 layers.

FINISH

Relief-Checking	Yes (surface normally forms fine micro cracks after welding)
Machine-able	No
Grind-able	Yes

