



HARD SURFACING ELECTRODE FOR SEVERE IMPACT

AC or DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

Smooth running electrode with a high deposition rate that produces even, non-cracking welds with long service life under heavy impact. Deposits have outstanding corrosion resistance and work harder under usual working conditions.

APPLICATIONS:

Repair and build-up of railroad tracks, frogs and switches. Joining high alloy steel to low alloy or unalloyed steel. Welding steels with high carbon, sulfur or phosphorus content. Surfacing low alloy and manganese steels. Commonly used for mill, quarry and gravel plant crushing hammers, rolls and mantles. Ideal for construction and mining equipment. Often used as an underlayment for more abrasion resistant materials.

TECHNICAL DATA:

Tensile Strength	106,000 psi (75 kg/mm ²)			
Yield Strength	62,000 psi (43 kg/mm ²)			
Elongation %	approx. 40			
Hardness	as welded - approx. 20 RC work hardened – approx. 45 RC			
Current	AC or DC reverse polarity (electrode+)			
Amperage	60-115	90-130	120-160	140-190
(in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

Remove surface that has been hardened or is not sound. Preheating is not recommended. Maintain a medium-short arc keeping it concentrated on the weld deposit to prevent excessive heat build-up in the part. Extra care should be taken to prevent overheating manganese steel because it changes the base metal structure. Peening while still hot helps to shape the part and reduce stresses. Allow to cool slowly.

Manufactured by **AmAlloy Industries®**
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