



Superior High Alloy Electrode with Excellent Abrasion and Good Impact Resistance - High Deposition Rate

AC or DC REVERSE POLARITY (ELECTRODE +)

GENERAL CHARACTERISTICS:

AM-865 is designed for use on carbon and low alloy steels, manganese steels and cast iron. Deposits take a high polish, which contributes to high frictional and abrasion wear qualities, especially small particle abrasion. Excellent on applications that need impact as well as abrasion resistance. Provides optimum resistance to this combination. Deposits well out of position.

APPLICATIONS:

AM-865 is recommended for severe abrasion applications, along with moderate impact. This alloy also has good hot hardness up to approximately 1,000°F. Especially designed for crusher applications. Used heavily in construction, mining, brick and clay industries on parts such as crusher rolls, jaw crushers, bucket teeth, edges, hammers, mill hammers, conveyor screws, etc.

TECHNICAL DATA:

Hardness	Rc 61-65		
Current	AC or DC reverse polarity (electrode +)		
Amperage	1/8	5/32	3/16
	80-125	100-160	125-190

PROCEDURE:

Remove any fatigued or unsound metal with AM-670. According to the thickness of deposit and type of base metal, a padding of AM-840, AM-850, or AM-700 might be considered. On cast iron, a base of AM-389 is recommended. Deposits can be applied as stringer beads; however, weave passes are recommended for maximum deposition rate. Prevent excessive heat build-up. Allow parts to cool slowly.

Manufactured by **AmAlloy Industries®**
To Order - Call: **507-373-1677** or **800-735-3040**
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www.amalloy.com