FILOTECH
Electrodes inc.

H A D - 2 0

OPEN-ARC FLUX-CORED REBUILDING WIRE

Characteristics

- a strong, martensitic matrix used for repairing heat treatable steels;
- resists corrosion, erosion, oxidation and abrasion at temperatures up to 900°F;
- most often used on carbon steel encountered in valves, screens, pump shafting and turbine blades;
- often used as a **non-cracking, multi-pass** hardfacing wire;
- costly gas shielding and/or cumbersome fluxing agents are not required;
- easily removable slag reveals a smooth slightly convex bead of shiny, modified, stainless steel.

Mechanical Properties

- Hardness as welded: 40 - 50 RC

Procedures

- DC reversed polarity, 26-32 Volts, 150-400 Amps.
- remove all damaged materials on surface to be welded
- preheat to 600°F
- avoid thermal shock
- stick-out: 2 - 3", (l - 2" for small diameter)

Applications:

- valves, turbine blades, aluminium melt tanks, steel rolls and casters, crusher parts, etc.

Other

- deposition rate: 10 - 20 lbs./hr.
- available in 7/64", 3/32", 5/64", 1/16" & .045" diameters
- packaging: 28 & 10 lb. spools, 100, 250, & 450 lb. pay-off-packs.

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