

Characteristics:

Hardness as deposited: 15-22
Hardness as work-hardness: 48-55
Tensile strength: 120,000 psi
Yield Strength: 70,000 psi
Elongation in 2 in.: 42%
Maximum layers: Unlimited

Parameters:

Diameter:	.045"	1/16"	7/64"
Current:	DCRP	DCRP	DCRP
Amperage:	145-195	150-275	350-450
Voltage:	18-24	25-28	26-30
Wire Extension:	1/2"-3/4"	1"-1 1/4"	1 1/2"-2"

Description:

Weldman A1 is a hardfacing wire that produces a high strength deposit that work hardens rapidly under impact. Best used for buildup/joining manganese steels, carbon steel and low alloy steel, where parts are subject to impact and abrasion. It is self-shielding. It is often used in applications of impactor bars, railroad crossings and crusher rolls. Weldman A1 uses DC straight or reverse polarity. It has poor machinability, no surface checks, high impact resistance and fair abrasive resistance.

Contains: carbon, silicon, nickel, chromium, manganese

Chemical Composition:

C	Mn	Si	Cr	Ni	Fe
0.3	15.0	0.3	3.6	3.5	BAL

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.