

Parameters:

Diameter:	.045"	1/16"	.035"
Current:	DCRP	DCRP	DCRP
Amperage:	170-225	175-300	90-150
Voltage:	24-28	26-32	17-22
Wire Extension:	1/2" -3/4"	1/2" -1 1/4 "	
Shielding Gas:	CO2 or 75/25 or no gas	CO2 or 75/25 or no gas	CO2 or 75/25 or no gas

Description:

Weldamatic D is self-shielding, chromium-boron hardfacing alloy and is best for parts subject to impact and abrasion. It has the highest hardness of any iron based alloy. Can be applied to carbon, alloy, manganese steels and cast iron. It has a highly refined grain structure and is often used in applications in the oil industry, agricultural, mining, construction, and brick and clay. Weldamatic D uses DC straight or reverse polarity. It has no machinability, grinding only, tight cross checks, good abrasion resistance, moderate impact strength and a hot wear service of 1100°F. Hardness as deposited (2 layers) is 62-64 with 2 to 3 layers recommended.

Contains: carbon, silicon, boron, molybdenum, chromium, manganese

Chemical Composition:

C	Mn	Si	Cr	B	Mo	Fe
2.1	0.3	1.0	10.1	0.8	0.4	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.