



a quality welding alloy

## ARCtec® 64 ECOFACE®

### GENERAL CHARACTERISTICS:

ARCtec® 64 ECOFACE® is a high alloyed electrode for hardfacing applications where high speed steel characteristics are desired. The deposit which is hard as welded, conforms to high speed steel, combining toughness, impact resistance and cutting edge retention. The weld metal will retain high hardness at elevated operating temperatures 595°C (1100°F) and can be heat treated.

### APPLICATIONS:

ARCtec® 64 ECOFACE® is suitable for hard overlays on cutting tools, dies, drills, knives, shears, punching dies, debarker knives, chisels, cutting blooms and billets. Ideal for final layer on cutting and piercing tools manufactured from low alloy steel.

### WELDING PROCEDURE:

Remove all foreign materials and fatigued metal from weld area. Preheat tool steel components to approximately 425°C (800°F) and maintain this temperature during the entire welding operation. No preheat is required when making deposits on low carbon steels. Remove slag between passes and allow workpiece to cool slowly. ARCtec® UNICROM® 265-S is suitable for use in conjunction with ARCtec® 64 ECOFACE® when a cushion layer or build up is required before hardfacing.

### MECHANICAL PROPERTIES:

	Hardness
As welded:	58 to 62 RC
Heat treated:	63 to 65 RC
Hardness at 595°C (1100°F)	Approx. 56 RC

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WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

### Recommended Amperage:

Diameter	2.5mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"
Amperage	70-90	90-120	130-150	150-180

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Subject to change without notice

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