



a quality welding alloy

ARCtec® FLEXTUNG 700

GENERAL CHARACTERISTICS:

ARCtec® FLEXTUNG 700 is a flexible tungsten carbide hard facing rod for use with the oxy-fuel brazing process. This rod consists of a nickel core wire coated with tungsten carbide particles in a Ni-Cr-B matrix. The deposit has extreme abrasion resistance. Machineable by grinding only.

APPLICATIONS:

ARCtec® FLEXTUNG 700 is particularly suited for hard facing of oilfield drill bits, drill stems, augers, asphalt plant mixer blades and other applications subject to severe abrasion and moderate impact.

WELDING PROCEDURE:

Clean the weld zone free of oil, grease, rust and other contaminants by grinding if necessary. **IMPORTANT:** Pre-spray cleaned surface with nickel powder to prevent oxidation during the brazing process. Apply with oxy-acetylene torch using a neutral flame. Large tip sizes that require high pressures may impede the uniform (homogeneous) distribution of tungsten carbide particles in the matrix. Preheat of large pieces is recommended prior to starting the brazing process. Allow the weld deposit and surrounding area to cool slowly.

MECHANICAL PROPERTIES:

Hardness	
Matrix:	40-45 RC
Carbide:	2950 HV

OPERATING PARAMETERS:

WELDING PROCESS: OFB

Melting Temperature: 950°C (1740°F) – 1050°C (1920°F)

	Available Diameters:		Particle Size	
	Inch	mm	In mm	US mesh
FLEXTUNG 700	5/32" on Spools	4.0 on Spools	0.25 – 0.70	24 – 60
FLEXTUNG 700	3/16" on Spools	5.0 on Spools	0.25 – 0.70	24 – 60
FLEXTUNG 700	1/4" on Spools	6.0 on Spools	0.25 – 0.70	24 – 60
FLEXTUNG 700	5/16" on Spools	8.0 on Spools	0.25 – 0.70	24 – 60

CALGARY FAX:(403)-250-7682	EDMONTON: (780)-484-4896	VANCOUVER: (604)-596-2940	WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355	(780)-484-3304	(604)-596-6207	(204)-663-9182

The seller makes no warranties, express or implied, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose, except as expressly stated in seller's contract, delivery slip or invoice form. Technical data and suggested application are provided to assist you in making your own evaluations and decisions and should not be interpreted as expressed or implied warranties. Mechanical properties are typical or average values obtained by testing and comparing many heats of the same alloys. Minimum and maximum values are noted accordingly and are not intended for specific purposes.

Subject to change without notice

OHO1612008/221-5