

ARCTEC® W 1030 CP



GENERAL CHARACTERISTICS:

ARCTEC® W 1030 CP is a low alloy, high deposition rate welding wire, that produces a sound, porosity free weld. Deposit can be flame cut and has good machinability. ARCTEC® W1030 CP requires no external shielding to produce sound deposits and will operate within a wide voltage and amperage range. Voltage tolerances are high enough to permit the use of variable speed wire feeders. ARCTEC® W 1030 CP will produce good results consistently when established FCAW buildup procedures are followed.

APPLICATIONS:

ARCTEC® W 1030 CP is used for buildup on most weldable steels. Typical applications include build up on: Tractor rails, cable drums, trunnions, mixer blades, steel shafts, gears, rail ends, rollers and idlers. May be used in the as welded condition or as preparation for hardsurfacing.

MECHANICAL PROPERTIES:

Typical Hardness
280-325 HB

CHEMICAL COMPOSITION:

This alloy is comprised of the following elements:

C Mn Si Cr Mo Fe

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS: Not required

Operating Range			
Diameter	Stickout ± .25"	Amps	Volts
.045" (1.2mm)	20-30 mm	100-220	18-24
1/16" (1.5mm)	20-30 mm	180-240	24-26
5/64" (2.0mm)	20-30 mm	220-280	25-27
3/32" (2.5mm)	20-30 mm	260-320	25-29
7/64" (2.8mm)	20-30 mm	300-360	26-30

STANDARD SIZE AND PACKAGING:

Size			Packaging
.045" 1.2mm	1/16" 1.5mm	5/64" 2.0mm	15Kg Spool
1/16" 1.5mm	3/32" 2.4mm	7/64" 2.8mm	25Kg Coils

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