



a quality welding alloy

ARCtec® W 1041 CP

GENERAL CHARACTERISTICS:

ARCtec® W 1041 CP is a chromium manganese austenitic type steel wire with outstanding work hardening capabilities. W1041 CP has exceptional joining, buildup and surfacing properties and produces crack free deposits. ARCtec® W1041 CP requires no external shielding to produce sound deposits and will operate within a wide voltage and amperage range with voltage tolerances that are high enough to permit the use of variable speed wire feeders and drooping type power sources. The smoke level is typical of a high manganese wire and the deposit is non magnetic, cannot be flame cut and is machinable by grinding only. The spatter level is low and no special welding techniques are required.

APPLICATIONS:

ARCtec® W 1041 CP can be used for carbon steel, manganese base materials. Mild or alloy steels may be joined or built up to the required deposit thickness Uses: Steel mill wobblers, shovel teeth, buckets and pads, rail frogs and crossovers, crusher rolls, hammermill hammers and impeller bars.

MECHANICAL PROPERTIES:

Yield Strength	Tensile Strength	Elongation	Typical Hardness	
			As Deposited	Work Hardened
83700psi	124000psi	37%-2"	220-250 HB	500 HB
577Mpa	854Mpa			

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
1/16"(1.5mm)	1.25"(31.75mm)	160-260	20-26
5/64"(2.0mm)	1.25"(31.75mm)	240-280	22-26
3/32"(2.4mm)	1.5"(38.10mm)	280-340	24-27
7/64"(2.8mm)	1.5"(38.10mm)	320-400	25-28

STANDARD SIZE AND PACKAGING:

Size			Packaging
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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