



a quality welding alloy

ARCTEC® W 1060 M

GENERAL CHARACTERISTICS:

ARCTEC® W 1060 M is a chromium carbon alloy, which develops a network of carbides in a tough austenitic matrix. This general purpose hard surfacing wire is low cost, very versatile and resists both high and low stress abrasion as well as moderate to heavy impact. ARCTEC® W 1060M 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 any conventional power source. The deposit is slightly magnetic and cannot be flame cut, machined or forged. No special welding techniques are required.

APPLICATIONS:

ARCTEC® W 1060 M can be used on carbon steel, manganese base materials and mild or alloy steels. Maximum recommended deposit thickness of 2-3 layers or 1/4". For use on: jaw or cone crushers, shovel teeth, hammer mill hammers, pug mill paddles, crusher roll shells, augers, plowshares and cultivator sweeps.

MECHANICAL PROPERTIES:

Typical Hardness As Deposited: 52 - 58 HRC

CHEMICAL COMPOSITION:

Typical chemical composition:

C Mn Si Cr Fe

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

SHIELDING GAS: Not required

POLARITY: DC Reverse

Operating Range		
Diameter	Amps	Volts
.045" (1.2mm)	100-220	18-24
1/16" (1.5mm)	160-260	20-26
3/32" (2.4mm)	280-340	22-26
7/64" (2.8mm)	320-400	25-28

STANDARD SIZE AND PACKAGING:

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

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