

# ARCTEC® W 1063



a quality welding alloy

## GENERAL CHARACTERISTICS:

ARCTEC® W 1063 is a high carbon, chromium, iron-based alloy which develops an austenitic carbide matrix with hexagonal chrome carbides. This hard surfacing wire provides weld deposits that are resistant to high and low stress abrasion and moderate corrosion while retaining good hardness at elevated temperatures. ARCTEC® W 1063 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 stress relieves (surface checks) readily upon cooling and cannot be flame cut, machined or forged. No special welding techniques are required.

## APPLICATIONS:

ARCTEC W® 1063 can be used for Carbon steel and mild or alloy steels which may be hard surfaced with a deposit thickness of 2-3 layers or 1/4" and is used on: Catalytic pipes and valves, Augers, Pusher shoes, Screw conveyors, Dredge cutters and pump impellers, Crusher roll shells, Bucket teeth and lips.

## MECHANICAL PROPERTIES:

Typical Hardness As Deposited  
58-61 RC

## CHEMICAL COMPOSITION:

This is a 34.5% total alloy content wire and is comprised of the following elements:

C      Mn      Si      Cr      Fe

## OPERATING PARAMETERS:

WELDING PROCESS: FCAW

SHIELDING GAS: Not required

POLARITY: DC Reverse

Operating Range			
Diameter	Stickout ± .25"	Amps	Volts
.045"(1.2mm)	1.5"(38mm)	120-240	18-24
1/16"(1.5mm)	1.5"(38mm)	180-240	24-26
3/32"(2.4mm)	1.5"(38mm)	240-320	26-30
7/64"(2.8mm)	1.5"(38mm)	300-360	28-32

## STANDARD SIZE AND PACKAGING:

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

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Subject to change without notice

OHOI40305/054-6