



**GENERAL CHARACTERISTICS:**

ARCTEC® WD 1063 is a high carbon, chromium iron based alloy that develops a high percentage of hexagonal chrome carbides. This yields a weld metal deposit that has excellent resistance to both low and high stress abrasion with moderate corrosion resistance at elevated temperatures. ARCTEC® WD 1063 requires no external shielding and produces a low slag volume that does not require removal between passes. The weld deposit readily stress relieves (surface checks), is non machinable and cannot be flame cut. No special welding techniques are required.

**APPLICATIONS:**

ARCTEC® WD 1063 wire provides good deposits with exceptional hot hardness to a deposit thickness of 2-3 layers or 1/4" as required. This excellent hard surfacing wire is used on: Crusher Rolls, Pipe Overlay, Augers, Pusher shoes, Sintering plant equipment, Bucket teeth, Shear Teeth, Hammermill equipment, Screw conveyors.

**MECHANICAL PROPERTIES:**

Typical Hardness As Deposited Hardness 58-61	Approximate Hardness At Elevated Temperatures Hardness 55 HRC	Test Temperature 1000 <sup>0</sup> F/537 <sup>0</sup> C
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**CHEMICAL COMPOSITION:**

This alloy is comprised of the following elements:

C      Mn      Si      Cr      B

**OPERATING PARAMETERS:**

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS: Not required

Operating Range			
Diameter	Stickout +/- .25"	Amps	Volts
1/16"(1.6mm)	1.5"(38mm)	180-280	20-26
3/32" (2.5mm)	1.5"(38mm)	260-340	26-30
7/64"(2.8mm)	1.5"(38mm)	300-380	28-30

**STANDARD SIZE AND PACKAGING:**

Size			Packaging
1/16"1.5mm			15Kg Spool
1/16"1.5mm	3/32" 2.4mm	7/64" 2.8mm	25Kg Coils
		7/64" 2.8mm	45Kg, 113Kg & 225Kg Drum

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

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