ARCTEC® 207 CNMG ALLOY STEEL

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 207 CNMG is a high deposition type electrode for joining and build up of various alloy steels. This electrode yields a tough, crack resistant weld deposit with excellent mechanical properties. It is very economical in use due to its high efficiency with a metal recovery of approximately 150%.

APPLICATIONS:

ARCTEC® 207 CNMG is particularly suitable for joining austenitic manganese steel to itself and carbon steel. Also recommended for build of machinery parts subjected to sliding wear and high impact loads, such as heavy construction equipment and as a cushion layer for hard overlays.

WELDING PROCEDURE:

Clean weld area free from oil, grease, rust and other surface contaminants. Bevel heavy section before welding. Maintain a short arc and use stringer beads to prevent overheating. A weave technique may be employed when applying cushion layers prior to hardfacing. Allow deposit to cool before removing slag. Preheating and postweld heat treatment is generally not required, but may be specified or recommended for some base material.

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			Impact Strength		
Tensile Strength	Yield Strength	Elongation	ft/lbs	Joules	Temperature
85,000 psi 585 Mpa	50,000 psi 345 Mpa	35 to 40% - 2"	44	60	20°C 68°F

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WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"	6.0 mm 1/4"
Amperage	80-100	110-130	150-170	180-220

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