



a quality welding alloy

ARCtec® 661 T HARD SURFACING

GENERAL CHARACTERISTICS:

ARCtec® 661 T is a tubular chromium carbide electrode that produces an overlay highly resistant to abrasion and moderate impact. The deposit is smooth and has good hot hardness (Up to 1000°F). This electrode operates over a wide range of amperage settings and can be used for out of position hard facing applications. Machinable by grinding only.

APPLICATIONS:

ARCtec® 661 T is suitable as a hard overlay in applications subject to abrasion under moderate stress conditions. Applications include kiln dampers, hammermills, slurry pipes, scavenger fans, asphalt plant mixer paddles and repair of chrome overlaid plate.

WELDING PROCEDURE:

Clean the weld zone free of oil, grease, rust and other contaminants by grinding if necessary. The weld deposit may be applied by using stringer or weave beads. Allow the weld deposit and surrounding area to cool slowly. Maximum deposit thickness three (3) layers.

MECHANICAL PROPERTIES:

Hardness
55 to 60 RC

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	6.0mm 1/4"	8.00mm 5/16"	12.7mm 1/2"
Amperage	80 - 110	140-200	200 - 425

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Subject to change without notice

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