

ARCTEC® WD 1042



GENERAL CHARACTERISTICS:

ARCTEC® WD 1042 is an economical high performance low phosphorous, austenitic manganese wire that produces a weld deposit with an austenitic microstructure. This wire produces sound, dense, high crack resistant weld deposits that will rapidly work harden. ARCTEC® WD 1042 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. The smoke level is typical of high manganese wires and the non magnetic deposit can be flame cut, spatter level is low, machinability is poor due to the rapid work hardening capabilities. No special welding techniques are required.

APPLICATIONS:

ARCTEC® WD 1042 wire provides good weld deposits for joining or build up of manganese to manganese or carbon steels that are resistant to high and low stress abrasion with moderate impact. Carbon steel, manganese base materials and mild or alloy steels may be repaired or surfaced with a deposit thickness of 2-3 layers. This is an excellent repair and build up wire and is used on: Crusher rolls and jaws, Shovel teeth and buckets, Hammermill hammers.

MECHANICAL PROPERTIES:

Tensile Strength 120000 psi (827 MPa)	Yield Strength 80000 psi (551 MPa)	Elongation 32%-2"	Typical Hardness	
			As Deposited 19 HRC	Work Hardened 50-55 HRC

CHEMICAL COMPOSITION:

This alloy is comprised of the following elements:

C Mn Si Cr Ni Fe

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS: Not required

Operating Range			
Diameter	Stickout ± .25"	Amps ± 75	Volts ± 1
7/64"(2.8mm)	1.5"(38mm)	400	27

STANDARD SIZE AND PACKAGING

Size	Packaging
7/64" 2.8mm	45Kg Auto Paks

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