



AMTEC 269 HEATALLOY FOR STEEL

AC/DC REVERSE ELECTRODE

General Characteristics

Amtec 269 Heatalloy is a specially formulated electrode that has a coating which produces a weldment with 170% metal recovery, depositing a nickel alloy for facings on hot work tools. Amtec 269 Heatalloy deposits are exceptionally tough and become work hardened during use without deformation of the weld deposit taking place. The weld metal performs very well under high compression and will retain its hardness up to 1000°F.

Procedure

Prepare the welding area with Amtec 8 gouging electrode, and grind the surface to remove any hard spots. Clean the welding area thoroughly. Ensure that the electrodes are kept dry. Preheating is advisable to 200-300°C (400-600°F), especially on heavier sections. In a case where large components are involved, we recommend the work pieces be preheated to 500°C (900°F) and they be cooled in still air following welding.

Application

Amtec 269 Heatalloy is used for the repair and build-up of hot working tools, hot shear blades, hot cutting blades, forging saddles, and piercing tools. It is also used as an overlay to resist corrosion on parts subject to oxidizing, and reducing atmospheres and liquids at temperatures up to 2000°F.

Tensile Strength	102,000 PSI
Yield Strength	58,000 PSI
Elongation	10%
Hardness (HB) (as deposited)	approx. 200
Hardness (HB) (work hardened)	approx. 400

Diameter (Inch)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

Amps (approx.)	80-100	90-130	120-170	160-220
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CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
269 Imprint