



## **AMTEC 60 ALL POSITION HARDSURFACING**

**DC REVERSE OR AC ELECTRODE**

### **General Characteristics**

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Amtec 60 is a very good, economical hardsurfacing electrode that can be used in all positions. This electrode has a specially designed flux that allows it to run as easy as low hydrogen electrodes. It is excellent for applications where impact and abrasion are a problem. The deposited weld metal is porosity free. This electrode can be used with multiple passes, up to three, without cracking or spalling. Can be used equally well on carbon and manganese steels.

### **Procedure**

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Clean the welding zone free from oil, rust and other contaminants. Keep the arc as short as possible. Hold the electrode in a slightly inclined position. Use stringer beads on most applications, however a weave bead of 3 times the electrode diameter is recommended when larger areas are being covered. If more than 3 layers are required, it is recommended to build-up with Amtec Railtec on carbon steel or Amtec 277 for alloy and manganese steels, then put the final layers of Amtec 60 on top, up to three (3) passes.

### **Application**

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For final overlays on crusher rolls, bucket teeth, impellers, mixer paddles, percussive drilling tools, bucket lips, grader blades, and mill hammers where heavy impact is a problem. Use on construction and mining equipment and also applying top layers over build-up on hard manganese steel machinery parts. If high abrasion with some impact is the problem, then Amtec 63 or Amtec 610 should be used.

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<b>Hardness (RC)</b>	<b>56-60</b>
<b>Wear Coefficient</b>	<b>2.8%</b>

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<b>Diameter (Inch)</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

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<b>Amps (approx.)</b>	<b>100-130</b>	<b>150-190</b>	<b>180-220</b>
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**CONFIDENTIAL INFORMATION**  
**Subject to change without notice**

**Tip Color – Green**  
**Amtec 60 Imprint**