



AMTEC 610 CHROME-MOLY-TUNGSTEN HARDSURFACING

DC REVERSE OR AC ELECTRODE

General Characteristics

Amtec 610 is a high chromium-tungsten-molybdenum iron based hardsurfacing electrode that is used for surfacing parts subject to high abrasion with moderate impact. Although the deposit has high hardness, it will still take moderate impact and will maintain its hardness up to a temperature of 1000°F. It is very easy to apply and has equally good welding properties for ease of application. Machinable by grinding only.

Procedure

Clean the weld zone of all contaminants and remove previous hardsurfacing deposits by using Amtec 8 gouging rod. Another method would be to overlay previous hardsurfacing with Amtec 207, to give a good base to put additional hardsurfacing onto. Use a medium arc gap for best results. A one layer deposit is recommended where possible to give the best possible wear resistance. Do not exceed a 2 layer deposit due to the chance of weld deposit cracking. Deposits should be put down in stringer beads. This electrode will cross check to stress relieve itself. This is normal with high hardness electrodes. Crack sensitive material such as alloy type steels should be preheated to 750-903°F (400-500°C) prior to welding.

Application

For final overlays on parts operating under severe abrasion conditions such as fine particle abrasion with some impact including crusher parts, coke pusher shoes, ash fan blades, feed mill hammers, bucket lips and teeth. Also used in higher heat applications such as steel mill blast furnace bells, hot slag dipper teeth and pug mill paddles.

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|--|---------------|
| Hardness (RC) 1st Pass | 60--65 |
| Wear Coefficient | 1.5% |

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

| | | | |
|-----------------------|---------------|----------------|----------------|
| Amps (approx.) | 90-130 | 270-230 | 175-275 |
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CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
Amtec 610 Imprint