



**AMTEC W1030 MC BUILD-UP FOR CARBON STEEL
DC REVERSE POLARITY METAL CORED WELDING WIRE**

General Characteristics

Amtec W1030 MC is a high hardness build-up wire with excellent compressive strength. It is recommended for any application where the weld deposits must provide metal-to-metal wear resistance, and still be machinable as welded. W1030 MC is for use on carbon and alloy steels only.

Procedure

Clean the welding zone free from oil, rust and other contaminants. Use DC reverse polarity at the following settings:

	SHORT ARC		SPRAY ARC	
Size:	.045	1/16	.045	1/16
Amps	90-200	150-220	250-325	300-375
Volts	15-21	18-21	27-30	27-30
Gas	Ar/CO2	Ar/CO2	Ar/Ox	Ar/Ox
CFH	25-30	25-30	40-45	40-45
Stick-out	1/2"	3/4"	5/8"	3/4"

If welding out of position, we recommend the use of the lower ranges of voltage (16-19) and amperages (100-150).

Application

Due to its hardness and wear resistance, Amtec W1030 MC wire is intended as a build-up and final overlay for carbon and cast steel machine components, steel mill parts, undercarriage parts of earthmoving and mining equipment, construction equipment, gear teeth, key ways and carbon steel railroad track components.

Wire Type: Metal Cored, gas-shielded, slag free deposit, carbon steel build-up welding wire.

Hardness (RC) 33-38 as deposited

Maximum number of passes: Unlimited

Deposits are machinable with carbide tools

Deposits can be flame cut

Alloy Content: Carbon, Chromium, Manganese, Silicon, and Molybdenum.

Standard Packaging and Sizes: .045 x 25 lb. spools

1/16 x 25 lb. Spools

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