



AMTEC W1040 FCO BUILD-UP FOR MANGANESE STEEL

DC REVERSE POLARITY FLUX CORED WELDING WIRE

General Characteristics

Amtec W1040 FCO build-up wire is an economical work-hardening austenitic manganese steel flux-cored open arc wire alloyed with chromium and nickel to improve weld deposit properties. It is designed for build-up and fabrication of manganese steel. Deposits are very tough, and work harden rapidly under high impact.

Procedure

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

Size:	.045	1/16
Amps	100-200	150-300
Volts	21-27	28-32
Gas	None	None
CFH	N/A	N/A
Stick-out	3/4"-1 1/4"	1" - 1 1/2"

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 W1040 FCO wire is intended as a build-up and final overlay for machine components made of manganese steel. Items such as crusher jaws, crusher cones and rolls, gyrator crusher mantels, hammer mill hammers and impact breaker bars, as well a manganese railroad frog and switch points.

Tensile Strength	120,000 PSI
Wire Type:	Flux Cored, open arc, manganese build-up welding wire.
Hardness (RC)	15-20 as deposited
Hardness (RC)	50-55 work hardened
Maximum number of passes:	Unlimited
Deposits are non-machinable	
Deposits can be flame cut	
Alloy Content:	Carbon, Manganese, Chromium, Nickel.

Standard Packaging and Sizes:	.045 x 25 lb. spools
	1/16 x 25 lb. spools
	7/64 x 55 lb. coils or 250 lb. tubs

CONFIDENTIAL INFORMATION: Subject to Change without Notice