

## Typical Weld Metal Properties

Hardness: 68-72 Rockwell "C"

## Recommended Parameters

FTC: approx. 2360 HV0.1

Wire Diameter	Coil size DIN EN 759	Amperage	Voltage
1/16	B 300 cages ca 15kg	120-160	16-20
3/32	B 435 cages ca 15kg	200-230	21-23
7/64	B 435 cages ca 25kg	220-260	21-23
1/8	B 435 cages ca 25kg	240-280	23-25

The area to be hard faced should be free of rust, scale, oil and other contamination. Be sure that the base material is not overheated and choose amps and volts as low as possible to avoid decomposition of the tungsten carbide.

NOTE: The base metal's alloy should have enough tensile strength so that the hard facing material cannot be pressed into it.