

ArmorWear™

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

(Continued)

Abrasion resistance	Good
Impact resistance	Good
Nonmachinable	Grinding only
Flame cutting	Difficult
Magnetic	
Heat-treatable and forgeable	
Maintains hot hardness up to 1000°F	

RECOMMENDED OPERATING PARAMETERS:

Diameter Inches mm	Type of Power*	Stick-Out		Amps	Volts
		Inches	mm		
.035	DCEN	1/2—5/8	13-16	80-120	15-18
				120-150	17-20
				150-190	18-21

Start with **middle ranges** and adjust accordingly. Higher amperages will increase deposition rate, dilution, and heat input to base metal. Increasing voltage will widen and flatten bead profile, but excessive voltage will result in porosity. Too much electrical stickout may result in increased spatter, too little may result in internal porosity.

*DCEN (straight polarity) is recommended. Satisfactory operation with DCEP (reverse polarity) also.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter	10 lb. Spool
.035	S605708-Z22

APPLICATIONS:

- Bucket lips and teeth
- Cultivator chisels and sweeps
- Plow shares, scraper blades
- Shanks, knives, teeth
- Kiln trunnions
- Spindles
- Pump components

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, # 130, Doral, FL 33166-6672 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

ArmorWear is a trademark of Hobart Brothers Company, Troy, Ohio.

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