

FabTuf® 960



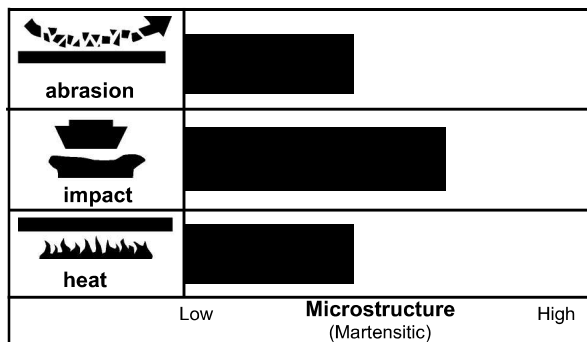
DESCRIPTION:

FabTuf 960 is a gas-shielded, metal-cored wire that deposits a martensitic alloy steel. It is designed for use as an overlay on carbon and low alloy steels. It has very good resistance to adhesive (metal-to-metal) wear and good resistance to abrasion and impact.

OPERATIONAL CHARACTERISTICS:

FabTuf 960 can be used with either 100% CO₂ or 75% Ar/25% CO₂ shielding gas. It has excellent operator appeal in all positions and produces a very smooth arc, low fume levels, and virtually slag-free welds.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis	
Carbon (C)	0.70
Manganese (Mn)	2.00
Silicon (Si)	1.00
Chromium (Cr)	8.00
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

Hardness	55 - 60 Rc
Abrasion resistance	Good
Impact resistance	Good
Machinability	Grinding only
Cannot be flame cut	
Magnetic	

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

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RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Stick-Out		Optimum Amps	Volts	Deposition Rate	
Inches	mm		Inches	mm			Amps	Amps
0.45	1.2	DCEP	1/2 - 1	13 - 25	120 - 160	19 - 23	130	4
					160 - 190	24 - 25	180	7
					190 - 230	26 - 27	220	10
1/16	1.6	DCEP	1 - 1-1/2	25 - 38	225 - 275	23 - 25	200	6
					275 - 350	24 - 27	250	10
					350 - 400	26 - 29	300	14

Use with 100% CO₂ or 75%Ar/25% CO₂ shielding gas. 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 stick-out may result in increased spatter, too little may result in internal porosity.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		33 lb. (15kg) Spool
Inches	mm	
.045	1.2	S234212-029
1/16	1.6	S234219-029

APPLICATIONS:

- Coupling Boxes
- Dragline Chain
- Kiln Trunnions
- Mill Guides
- Sprindles
- Ore Drag Lines
- Dredge Parts
- Muller Tires
- Extruder Worms
- Conveyor Bucket Lips Coal Conveyors
- Wobbler Ends

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, 550 NW LeJune Road, Miami, FL 33126 (can 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. Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

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

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