

Tube-Alloy[®] 258-G

TYPICAL MECHANICAL PROPERTIES* (As Welded):

(continued)

Abrasion resistance	Good
Impact resistance	Good
Nonmachinability in as-welded condition - grinding only	
Flamed cutting	Difficult
Good resistance to softening at elevated temperatures	
Heat treatable	
Good dimensional stability	

RECOMMENDED OPERATING PARAMETERS:

Diameter Inches	mm	Type of Power	Stick-Out Inches	mm	Optimum Amps	Volts	Deposition Rate Amps	lb/hr
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 98% Ar/2% O₂ 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 Inches	mm	33 lb. Spool	50 lb. Spool
.045	1.2	S595412-029	—
1/16	1.6	—	S595419-027

APPLICATIONS:

- Clean Out Rings
- Die Holders
- Dummy Blocks
- Extrusion Dies
- Forming Dies
- Forging Dies
- Header Dies
- Hot Forming Dies
- Gripper Dies
- Guide Rolls
- Mandrels
- Swaging Dies

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 36th St., Miami, FL 33166 (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

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.

Hobart and Tube-Alloy are registered trademarks of Hobart Brothers LLC, Troy, Ohio.

Revision Date: **180709** (Replaces 160523)
260-G, INDEX

