



PRODUCT DATA SHEET



ArcoBuild-Up EasyGo – SS (Self- shielded)

ArcoBuild-Up™ is a family of alloys suited to Build up for reclamation, Buttering layers or Dissimilar joining of a range of medium alloy and high alloy materials and castings

CLASSIFICATIONS	AWS A 5.22 E307T0-3 EN 12073 T18 8 Mn U N 3 AS/NZS 2576-2005, 1320-B7
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ArcoBuild-Up EasyGo-SS is a self-shielded welding wire manufactured from high grade ferro-alloy additives and manufactured to exact formulation providing excellent weld characteristics and service.

EasyGo-SS is designed for Build – UP and joining of a range of high strength steels and produces a work hardening Austenitic weld deposit, work hardening responds to the amount of loading or impact applied, this alloy is highly suitable to reclamation or rebuilding components subject to high impact service conditions, corrosive environments and for a buttering layers to retain base metal integrity when applying Carbide hardfacing overlay.

Work hardening responds to the amount of loading giving a balanced level of hardness.

For joining applications where high toughness & strength is required EasyGo-ss can be used for dissimilar weldments between a range of metals and castings including 14% Hadfield type steel, Mild steel, stainless steels, Q&T, Armouring and hardenable steels to themselves or to each other. Due to the Austenitic Microstructure hydrogen induced cold cracking can be avoided and preheat can be reduced.

Applications

Crushing equipment including mantles, mining equipment components, shredder shafts, milling equipment, Joining of Q&T steel for mining buckets, Fixed & Mobile plant repairs, Metal recycling shredder discs.

Gas shielding not required, torch electrode Positive polarity (DCEP)

Typical All- Weld Metal Composition (Weight%)

C	Mn	Si	Cr	Ni	Fe
0.10	6.0	0.5	19.0	9.0	Balance

Typical All- Weld Metal Mechanical & Hardness range

5-9 HRc (As Welded)		40-45 HRc (Work Hardened)	
166- 178HB		374- 420HB	
Yield point (Mpa)	Tensile strength (Mpa)	Elongation (%)	Charpy J / Temp
480	630	39	50 @ +20°C

PACKAGING
15kg,

Wire diameter Sizes
1.6mm