



PRODUCT DATA SHEET



ArcoHard 965 AP – GS (Gas- shielded)

ArcoHard™ is a family of alloys suited to Build up and reclamation to specific Hardness. Machinable or protective layers "As Welded" (Controlled welding conditions).

CLASSIFICATIONS	AS/NZS 2576-2005, 1855-B5 EN 14700 T Fe 55 GSP
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ArcoCrush 965 is an All-Positional, Flux cored arc welding hardfacing wire manufactured from high grade ferro-alloy additives and manufactured to exact formulation providing excellent weld characteristics and service performance.

Suited to gas- shielded (GS) hardfacing in the down hand, vertical or overhead positions, the weld deposit contains a medium alloyed martensitic microstructure with great impact resistance and high hardness. Weld deposit can be left as welded or ground to suit dimension, however, machinable with tooling specified for high hardness may be possible.

Used for final reinforcement layering on components subject to metal to metal abrasion or ground engaging tools and for armouring high wear zones subject to fine abrasion by a range of materials. Also used for surface cladding in-situ joints of wear plates.

Applications

Agricultural equipment and tillage points, cement industry components, augers, slurry pipework cladding, earthmoving equipment. Compactor wheels, Bucket edges/lips, shredders for wood or rubbish, recycling machinery

Post weld Relief checking is normal without preheat.

Gas shielding uses a mixed gas of Argon with 15% or 25% Co², torch electrode Positive polarity (DCEP)

Typical All- weld Metal Composition (Weight%)

C	Mn	Si	Cr	Mo	V	Fe
0.50	2.5	0.8	8.0	0.6	0.3	Balance

Typical All- weld Metal Hardness range

54-59 HRc (1 layer)	55-60 HRc (3 layer)
534- 620HB	550- 630HB

PACKAGING
15kg,

Wire diameter Sizes
1.2mm, 1.6mm