



PRODUCT DATA SHEET



ArcoHard Build Up 1 – SA (Submerged Arc)

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, 1125-B1 EN 14700 T Fe1 250 P
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Arcohard Build UP 1 - SA wire is manufactured from high grade ferro-alloy additives and manufactured to exact formulation providing excellent weld characteristics and service performance.

Suited to Submerged Arc (SA) welding process in the down hand position, the weld deposit is Low alloyed medium hardness and machinable ideally suited to heavy reclamation and cladding for build up of large industrial components.

Applications

Agricultural equipment, earthmoving equipment such as Idlers, track pads, sprockets, shafts, Compactor wheels, recycling machinery

Post weld Relief checking is normal without preheat.

Suited to use with BasiFlux H+, torch electrode Positive polarity (DCEP)

Typical All- weld Metal Composition (Weight%)

C	Mn	Si	Cr	Mo	Fe
0.12	1.10	0.3	1.3	0.5	Balance

Typical All- weld Metal Hardness range

24 HRc (3 layer)
250HB

PACKAGING
300kg, 25kg

Wire diameter Sizes
2.0mm, 3.2mm