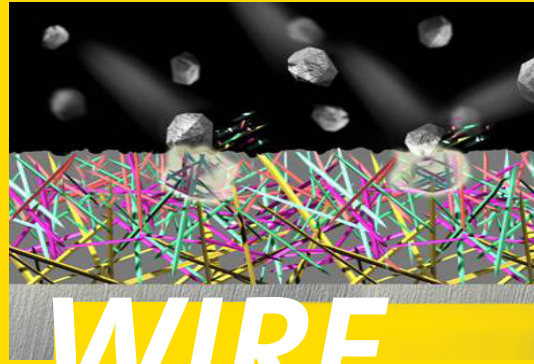


Open Arc Wearfacing Wire Specifically Formulated
for use on Manganese Steel

TeroMatec[®] 0A 3206



WIRE

- Excellent resistance to impact and pressure
- Rapid work hardening
- No cracking due to the addition of critical alloying elements
- High deposition rate with high weld metal yield
- Recommended for outdoor use



DESCRIPTION:

Teromatec OA 3206 is designed to produce deposits with high toughness and better work hardening characteristics. Multi-layered deposits of this alloy have high resistance to the combined stresses of compression and severe impact.

Special formulation with the addition of stabilizers to minimize carbide precipitation in the grain boundaries. Excellent buildup properties with less chance of cracking.

TYPICAL APPLICATIONS:

Battering tools, crusher rolls, end-plates, grizzlies, impeller bars, jaw crushers, latch bars, quarry augers, excavator buckets, ripper teeth, wear plates, gyratory crushers & mantles.

TECHNICAL DATA:

Hardness:	23-26 HRC (as deposited)
Work hardened hardness:	40-45 HRC
Max. number of passes:	Unlimited but practical at 2in (50mm)
Current Polarity:	DCEP (DC+)

OPEN ARC PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	WIRE STICK-OUT
1.6 mm (1/16")	24-27	140-250	25-38 mm (1 - 1.5")
2.0 mm (5/64")	22-28	160-275	25-38 mm (1 - 1.5")
2.8 mm (7/64")	25-30	225-375	51-63 mm (2 - 2.5")

WELDING PROCEDURE:

Preparation:

Clean weld area of scale and/or oxide. A nominal preheat of 65°C (150°F) is advised if part is below 5°C (40°F) or over 25 mm (1") thick. For higher carbon steels higher preheats will be needed. Do not preheat manganese steel castings above 205°C (400°F) as this will cause time-temperature embrittlement.

Technique:

Maintain the optimum electrode stickout and hold a 75° angle from the vertical in the direction of travel. Do not weave excessively. Wide beads can cause porosity, excessive base metal overheating, and degrade the weld deposit wear properties. Back whip craters to reduce cracking tendencies and potential out-gassing.

Post-welding:

Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket or by other means. If steel composition is unknown, slow cool at a rate of 38°C (100°F) per hour.

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