



# BUILD-UP & HARDFACING OPEN ARC Flux-Cored Wire

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)

Quality Management System  
in accordance with  
ISO 9001:2000  
Cert # 05-R0925



## NI-MANG 14-O Open Arc Build-up & Joining Wire

This Open Arc, flux cored wire version of our Ni-Mang 14 Electrode, is designed for high impact conditions and for joining wear plate to manganese steel. A new application for Washington Alloy's Ni-Mang 14-O has found great success with back hoe pile driver blades. Building up the blade with Ni-Mang 14-O and then capping the deposit with our new 800HT-O has proven to increase the production life of back hoe pile driver bars substantially.

- \*Deposited hardness up to 20 RC
- \*Work hardens to 45-55 RC
- \*Tensile strength up to 120,000 PSI
- .045 – 160-220 Amps, 20-25 Volts
- \*Packaging: 10 or 25 LB spools or 50 lb coils
- \*Use DC welding current, straight or reverse polarity
- \*Elongation up to 40%
- 1/16 – 170-350 Amps, 22-30 Volts  
(7/64 Available upon request)

**TYPICAL APPLICATIONS:** Crusher Jaws, Hammers and roll shells. Excellent for railroad tamper bars and tracks, joining of wear plates to manganese steels, build-up of parts exposed to high impact and manganese buckets, prior to hardfacing.

## 800HT-O Open Arc Hardfacing Wire for Extended Wear

This outstanding, “**Severe Extreme Abrasion Resistant**”, open arc flux cored wire, is an excellent replacement for several wear resistant wire types. Even tungsten-carbide filled wire and electrode types can be replaced with this outstanding, versatile wire. Due to high alloy content, this wire has a two-pass limit. Any previous layers should be worn off or removed.

**800HT-O is a high alloy wire and is designed to out-perform 100 and 101 series wires by providing a much improved abrasion resistance and longer service life**

- \*As deposited hardness up to 63RC
- \*Use DC Welding Current, straight or reverse polarity.
- .035 100-150 Amps, 18-25 Volts
- .045 150-225 Amps, 20-25 Volts
- 1/16 170-350 Amps, 22-30 Volts
- \*Packaging: 10 LB or 25 LB spools
- .035 x 1 LB spools & 1/16 and 7/64 x 50 LB coil/special order

**APPLICATIONS** include, but are not limited to, severe abrasion on back hoe buckets and pile hammers, drag line buckets, front end loader buckets, tillage tools, drill stem collars, coat pulverizer blades, etc.

EAST COAST  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

GULF COAST  
4855 Alpine Drive #190  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

WEST COAST  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586



8-2007 DC

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

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