CRCARB-O is designed to deposit an alloy composed of a high density of primary chromium carbides in a semi-austenitic iron matrix. It is considered the most economical of hard-facing alloys in high wear applications. Deposit has high abrasion resistance with moderate impact resistance. Can be applied in multiple layers depending on application. Weld deposit will stress relieve itself by crack checking. Can be used in applications up to 1,100 F. Wire is designed for self-shielded welding but additional 100% CO2 gas shield may be used. 2-layer max recommended.

Grinding rolls, augers, drill stems, mining bucket and teeth over-laying wear plate, clad pipe, dredge pump components, rock crushing hammers, ditcher teeth, plow, cultivator points

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>Wire Speed (ipm)</th>
<th>Amps</th>
<th>Volts</th>
<th>Electrical Stickout</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.035</td>
<td>275-520-780</td>
<td>70-100-160</td>
<td>19-20-24</td>
<td>3/8-3/4”</td>
</tr>
<tr>
<td>0.045</td>
<td>200-370-600</td>
<td>100-150-205</td>
<td>21-25-30</td>
<td>1”- 13/4”</td>
</tr>
<tr>
<td>0.052</td>
<td>160-340-500</td>
<td>120-175-390</td>
<td>22-27-30</td>
<td>1”</td>
</tr>
<tr>
<td>1/16”</td>
<td>150-320-390</td>
<td>140-230-375</td>
<td>24-28-31</td>
<td>1”-2”</td>
</tr>
<tr>
<td>5/64”</td>
<td>120-250-300</td>
<td>250-385-450</td>
<td>26-29-32</td>
<td>3/4-1 1/4”</td>
</tr>
<tr>
<td>3/32”</td>
<td>110-185-275</td>
<td>300-425-550</td>
<td>25-29-34</td>
<td>3/4-1 1/4”</td>
</tr>
</tbody>
</table>

- **Typical weld chemistry (%) and weld metal properties:**
  - Carbon: 1.25-3.75
  - Chromium: 8.5-11.25
  - Manganese: 1.75 max
  - Boron: 1.75 max
  - Silicon: 0.5-3.5
  - Molybdenum: 0.25-1.20
  - Zirconium: 0.5-3.5
  - Iron: Balance
  - Hardness (two layers): HRC 62-64
  - Temperature rating: 1000°F
  - Impact strength: Moderate
  - Abrasion resistance: Excellent
  - Cross Check Deposit: Yes
  - Machinability: No

**Available sizes:**

THF CRCRB-O = Spools of .035, .045 1/16”

Other sizes available – please inquire (800HT in the past)

**Specifications:**

**East coast**
- 7010-G Reames Rd, Charlotte, NC 28216
- Tel: (888) 522-8296
- Fax: (704)598-6673

**West coast**
- 8535 Utica Ave, Rancho Cucamonga, CA 91730
- Tel: (800)830-9033
- Fax: (909)291-4586

Warehouse Distribution centers – Dallas/Fort Worth, Portland, Oregon & Boston, Massachusetts head office – Puyallup, Washington

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