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

0.045 – 160-220 Amps, 20-25 Volts
0.035 – 100-150 Amps, 18-25 Volts

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.

0.035 100-150 Amps, 18-25 Volts
0.045 150-225 Amps, 20-25 Volts
1/16 170-350 Amps, 22-30 Volts

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.