

CARBALOY 1

JOINING AND BUILD-UP ALLOY FOR SEVERE IMPACT OF COMPRESSION RESISTANCE

AC OR DC EITHER POLARITY

GENERAL CHARACTERISTICS:

Carbaloy 1 is a tough, high-strength electrode for use where high impact or high compression strength is needed. Weldable in all positions, Carbaloy 1 applies easily with minimum spatter loss. The non-popping slag is easily removed. Deposits are nonmagnetic and can be flame-cut or forged.

APPLICATIONS:

Excellent for manganese or manganese-to-steel applications. Specially formulated for use on the railroad industry. Additionally, it's good compressive strength makes it ideal as build-up prior to hardfacing. Also excellent for high impact situations like crusher roll build-up, crusher jaws, hammer mill hammers, bucket teeth, etc. No limit to deposit thickness.

TECHNICAL DATA:

Hardness	Rb 83-91 as welded
.....	Rc 30-41 work hardened
Tensile Strength.....	116,000 psi (800 N/mm ²)
Elongation	38%
Forgeability	Yes
Machinability	Yes, with carbide tool
Current	AC or DC reverse or straight polarity (electrode +/-)
Amperage 125-170 160-225 225-390	
(in) 5/32 3/16 1/4	
(mm) 4.0 5.0 6.0	

PROCEDURE:

Remove all dirt, grease and surface scale. Prepare crack or remove any brittle or work hardened surfaces with Chamferrode. Use suggested amperage to get proper weld shape. Keep weld interpass temperature as low as possible; do not exceed 500°F (260°C).

BUILD UP CARBALOY 1