

CARBALOY 12

SPECIAL ALLOY FOR DIRECT CAST IRON HARDFACING

AC OR DC EITHER POLARITY (ELECTRODE±)

GENERAL CHARACTERISTICS:

This unique alloy formulation is outstanding for use on cast iron. This electrode does not need any nickel or nickel iron buffer layers. It was specially designed to rebuild cast iron or GM 241 automotive forming dies. It is also excellent for applications involving chrome plating after welding.

APPLICATIONS:

This unique alloy formulation is outstanding for use on cast iron forming dies and trimmer dies.

TECHNICAL DATA:

Typical Deposit Chemistry C .05 Mn 1.8 Si 1.1 CR 4 Ni, Mo, Co, Fe and others Balance

Hardness as welded 1st layer RC 30

as welded 2nd, 3rd, etc.. layersRC 40

Current AC or DC Either Polarity (electrode ±)

Amperage 80-110 100-120

(in) 1/8" 5/32"

(mm) 3.2 4.0

PROCEDURE:

Base material must be absolutely free of oil and other impurities. Preheat of the base metal is not required in most applications. For the best results use the lowest possible amperage for low penetration. The stringer bead technique is essential to avoid overheating the base metal. Peening the bead after each pass is recommended to relieve stress and avoid cracks.

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