

Weartech™ WT-6 TIG

AWS A5.21 ERCoCr-A • Hardfacing

Typical Applications

- ▶ Shear Blades
- ▶ Fluid Flow Valves
- ▶ Extrusion Screws
- ▶ Roll Bushings
- ▶ High Temperature
- ▶ Valve Bearing Surface

Welding positions

All

Welding Processes

- ▶ Gas Tungsten Arc Welding
- ▶ Oxyfuel Welding

DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Carton
1/8 (3.2)	B1060-320X915
5/32 (4.0)	B1060-400X915

DEPOSIT COMPOSITION

	%C	%Mn	%Si	%Cr	%Ni
Requirements					
AWS A5.21 ERCoCr-A	0.9-1.4	1.0 max	2.0 max	26-32	3.0 max
Typical Results	1.1	0.1	1.3	28.2	2.5
	%Fe	%Mo	%W	%Co	Hardness, Rc
Requirements					
AWS A5.21 ERCoCr-A	3.0 max	1.0 max	3.0 -6.0	Balance	Not Required
Typical Results	2.5	0.1	4.7	59	42

TYPICAL OPERATING PROCEDURES

Polarity	Current (Amps)		
	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
DC-	115-135	145-165	175-195

Diam.	4.54 kg Pack
3.2mm	WT-632
4.0mm	WT-640

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