

# Weartech™ WT-12 TIG

AWS A5.21 ERCoCr-B • Hardfacing

## Welding Positions

All

## Applications

- ▶ Chain Saw Bars
- ▶ Saw Teeth
- ▶ Extrusion Dies

## Welding Processes

- ▶ Gas Tungsten Arc Welding
- ▶ Oxyfuel Welding

## DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Carton
1/8 (3.2)	B1120-320X915
5/32 (4.0)	B1120-400X915

## DEPOSIT COMPOSITION

	%C	%Mn	%Si	%Cr	%Ni
<b>Requirements</b> AWS A5.21 ERCoCr-B	1.2-1.7	1.0 max	2.0 max	26-32	3.0 max
<b>Typical Results</b>	1.4	0.1	1.4	29.5	2.5
	%Fe	%Mo	%W	%Co	Hardness, Rc
<b>Requirements</b> AWS A5.21 ERCoCr-B	3.0 max	1.0 max	7.0 -9.5	Balance	Not Required
<b>Typical Results</b>	2.6	0.1	8.8	53	47

## TYPICAL OPERATING PROCEDURES

Polarity	Current (Amps) 1/8 in (3.2 mm)
DC-	115-135

Diam.	4.54 kg Pack
3.2mm	WT-1232
4.0mm	WT-1240

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