

Typical Applications:

- Hardfacing of surfaces subjected to severe abrasion
- Drilling, dredging, and mining equipment

Product Advantages:

- Exceptionally low wear rate of 0.23g/6k revs (ASTM G-65)
- Hardness: 62 HRc

Typical Deposit Composition Range

	%C	%Mn	%Si	%Ni	%Cr	%V	%Ti	%Co	%B	%W
Texas Tough 1	0.7 max	2 – 2.5	1 max	1 – 2	3.5 – 4.5	1 – 2	1.5 max	0.5 max	3.5 – 4.5	1.5 – 2.5

Available Diameters: 1/16” (Additional sizes may be available upon request)

Typical Welding Parameters

Diameter	Shielding Gas	Amperage Range	Voltage Range	Current
1/16”	100% CO ₂	225 – 275	27 - 28	DCEP

Packaging: The product is packaged on 25 or 50lb. spools with a vapor corrosion inhibitor strip, vacuum-packaged and placed in a specially designed carton for long term storage.

Moisture Control: Electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice.

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