



FUSION™ Ti is a Flux cored hardsurfacing wire which produces a chrome titanium iron deposit. The weld deposit contains finely dispersed titanium carbide particles in a high chromium martensitic tool steel like matrix. **FUSION™ Ti** should be used for hardfacing components subjected to both severe gouging and grinding abrasion as well as heavy impact.

Typical Deposit Characteristics

Abrasion Resistance	Excellent
Hardness	HRC 56 – 60
Impact Resistance	Heavy
Deposit Layers	3 Layer Average
Position	Flat, Horizontal
Surface Cross Checks	Little to none, with proper preheat & interpass temperature
Machinability	Material is too hard to be machined. Recommended for grinding only.
Hot Wear Applications	1110° F (600° C) Maximum

Operational Characteristics / Welding Parameters

Diameter, in (mm)	1/16" or 0.045"
Current, Amp DCEP	150 – 350A 100 – 300A
Wire Feed Speed	120 – 300 IPM 150 – 450 IPM
Voltage	23 – 33 21 - 31
Wire Extension, in	¾" – 1 ¾" ½" – 1 ½"
Shielding Gas (Not Required)	If Desired: 100% Ar -OR- 100% CO ₂ -OR- 75% Ar / 25% CO ₂

TYPICAL ALL-WELD METAL ANALYSIS							
C	Mn	Si	Cr	Mo	Ti	V	Fe
1.7	1.2	1.30	7.0	1.2	5.1	0.2	Bal

Alloy Type

Finely dispersed titanium carbide particles in a high chromium martensitic tool steel like matrix.

Typical Applications

- Brick Dies
- Slurry Pipes
- Mixers Tyres
- Mining Equipment
- Cane Knives
- Scraper Blades
- Shovel Buckets
- Augers

Standard Sizes & Packaging

Diameter:	1/16" (1.6 mm)	OR	0.045" (1.2mm)
Packaging:	55 lbs. Coil	OR	33 lbs. Spools