



ISO 9001:2015 Certified

**CHROME WELD FUSION-GO** is a unique chrome free hardfacing wire, meant for particularly high abrasive wear and moderate impact applications. Being chrome-free there is no hexavalent chromium produced by the welding wire when being used, eliminating health concerns. The special formulation allows you to produce excellent abrasion resistance in a single layer. It can be applied to carbon, low alloy, or manganese steels and can be used in hot wear applications up to 1100°F. No shielding gas is required for this welding wire making it a convenient material to work with. CHROME WELD FUSION-GO hardfacing wire is formulated to be used in applications where sand and earth are the main wear material.

## Typical Deposit Characteristics

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Hardness	HRC 60 – 65
Machinability	No
Deposit Layers	2 Layer Max. (Based on 1/8" thickness per layer)
Surface Cross Checks	Yes
Hot Wear Applications	Up to 1100°F

## Operational Characteristics/Welding Parameters

Diameter, In. (mm)	0.045 (1.2)
Current, Amp. DCRP	100-300
Voltage	21-35
Wire Extension, in (mm)	1/2" – 1-1/2" (12.5-38)
Shielding Gas (Not Required)	100% CO <sub>2</sub> OR 75% Ar / 25% CO <sub>2</sub>
Position	Flat, Half Up, Half Down

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Ni	B	Ti	Fe
0.5	2.00	1.30	2.00	4.50	0.3	Bal

## Alloy Type

Boron carbides in a martensitic matrix.

## Typical Applications

- Buckets/Shovels
- Mining Equipment
- Slurry Pipes
- Drag Line Components
- Chutes/Hopper
- Dredge Parts

## Standard Sizes & Packaging

Diameter: .045" (1.2mm)  
Packaging: 33# Spools