



ISO 9001:2008 Certified

CHROME WELD FUSION-W is a Flux cored hardsurfacing wire containing 50-60% tungsten carbides. It has a combination of toughness and wear resistance, due to the heterogeneous weld metal composed of tungsten carbides distributed in a hard and very tough matrix. Unlike many others, this welding wire has exceptional wetting characteristics. It performs best in applications that endure extreme abrasion combined with corrosion.

Typical Deposit Characteristics

Abrasion Resistance	Excellent
Hardness	HRC 52 – 55
Impact Resistance	Moderate
Deposit Layers	1 Layer Average (2 Layers Depending on Application)
Position	Flat, Downhand
Surface Cross Checks	With cracks
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)	0.063 (1.6 mm)
Current, Amp DCEP	130-160A 17-19V Pulling Technique
Wire Feed Speed (m/min)	120-140 (3.2)
Voltage	19 - 22
Wire Extension, in (mm)	1" – 1.5" (25 - 40)
Shielding Gas	98% Ar + 2% O ₂ or 100% Ar

Alloy Type

Ni + Cr + Si + B Matrix

Typical Applications

- Brick/Clay Mill Augers
- Earth Moving Equipment
- Rubber Mixers
- Mining Equipment

Standard Sizes & Packaging

Diameter: 0.063" (1.6 mm)
 Packaging: 33# Fiber Spools