Austenitic Hardfacing Electrodes and Wires

Designed for low abrasion resistance and high impact situations.

Superior Advantages

- Work hardens under heavy impact conditions
- Unlimited pass-over-pass applications
- High operator appeal – smooth running, quiet and minimal sparks

Applications

- Bucket teeth
- Hammer mill and mill swing hammers
- Tampers and jackhammers
- Impactor crusher bars

Certanium® Alloys

282FC MIG Wire

Buildup and overlay of austenitic manganese steels only

Tensile Strength: 120,000 PSI

Hardness: Up to Rc 55, work-hardened

No. of Passes: Unlimited

Polarity: DC Reverse

Gas: None or 75% Ar, 25% CO_2

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.045	**P19575**	25
1/16	**P19574**	25

Cronatron Alloys

777 Electrode

For severe impact and extreme shock (torch cuttable)

Tensile Strength: 115,000 PSI

Hardness: Rb 54

Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
1/8	100 – 150	**CW1063**	5
5/32	130 – 170	**CW1062**	5
3/16	150 – 220	**CW1061**	5

7109M-FC MIG Wire

Buildup and joining of manganese steels and carbon steels

Hardness: Up to Rc 54 (3rd pass)

No. of Passes: Up to three

Polarity: DC Reverse

Gas: None or 75% Ar, 25% CO_2

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.045	**CW5146**	10
.045	**CW3587**	25
1/16	**CW3588**	25
7/64	**CW1929**	55

777M-FC MIG Wire

Joining, buildup and overlay of austenitic manganese steels only

Tensile Strength: 120,000 PSI

Hardness: Up to Rc 55, work-hardened

No. of Passes: Unlimited

Polarity: DC Reverse

Gas: None

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16	**CW4800**	25

7108 Electrode

Chromium-enriched alloy for overlaying austenitic manganese steel (non-torch cuttable)

Tensile Strength: 120,000 PSI

Hardness: Up to Rc 55, work-hardened

No. of Passes: Unlimited

Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
5/32	125 – 190	**CW2051**	5
3/16	150 – 260	**CW2052**	5

Hardfacing Buildup Electrodes and Wires

Alloys for repairs and buildup prior to overlaying with more abrasion-resistant hardfacing.

Superior Advantages

- Versatile – easy to use on all steels
- Resists cracking
- Increased deposition rates save time and money
- Work hardens under impact

Applications

- Shaft buildup
- Equipment part repairs – gears, booms, crusher rolls and hammers
- Welding alloy steel to manganese steel
- Frogs and switch points

Certanium® Alloys

706 Electrode

Buildup on all types of steel

Tensile Strength: 101,000 PSI

Elongation: 34%

Hardness: Rc 45, work-hardened

Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	65 – 100	**P12785**	10
1/8	110 – 150	**P12775**	10
5/32	160 – 200	**P12675**	10
3/16	225 – 270	**P12665**	10
1/4	250 – 350	**P12961**	10

706FC MIG Wire

Tensile Strength: 95,000 PSI

Elongation: 38%

Hardness: Rc 45, work-hardened

Polarity: DC Reverse

Gas: None

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.045	**P19535**	10
.045	**P19557**	33
1/16	**P19543**	25

Cronatron Alloys

7770 Electrode

All-position alloy for buildup on all types of steel

Elongation: 35%

Hardness: Rc 45, work-hardened

Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	65 – 90	**CW1881**	5
1/8	115 – 145	**CW1880**	5
5/32	155 – 190	**CW1879**	5
3/16	220 – 270	**CW1878**	5
1/4	250 – 350	**CW1876**	5

7770M-FC MIG Wire

Elongation: 35%

Hardness: Rc 45, work-hardened

Polarity: DC Reverse

Gas: None

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.045	**CW1779**	10
.045	**CW1781**	25
1/16	**CW1780**	25
3/32	**CW1788**	55