



# TENSAWELD ULTRA-100 HARDFACING

## DESIGNED FOR IMPACT STRENGTH

### DESCRIPTION

- Tubular wire for gas shielded metal arc **hardfacing**
- Provides martensitic weld metal with good abrasion and impact resistance
- Abrasion resistant cover pass for structural/plug welds in AR plates
- Especially applicable in 2-3 layers for wear resistance
- Welding positions: Flat, half up, half down
- 100% compatibility with Tensalloy™ products

### CONDITIONS OF USE

Current Type	Protection*
DC (+)	Gas Shielded (Ar - 2% O <sub>2</sub> )

### PACKAGING

Diameter	Standard	Weight
0.45"	Spool EN759 ' BS300	33 lb spool
1/16"		

### TYPICAL WELD DEPOSIT CHEMISTRY (CO<sub>2</sub>)

C	0.5
Mn	1
Cr	7
Si	0.5
Structure: medium alloy martensitic	

### RECOMMENDED WELDING PARAMETERS

Diameter		Amperage (A)		Voltage		Stick-Out (in.)		Recovery
mm	in.	Range	Optimum	Range	Optimum	Range	Optimum	
1.2	0.045	150-250	250	24-30	28	0.75-1.25	0.75	90%
1.6	1/16	200-300	270	25-30				

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED. Fumes from the normal use of some welding products can contain significant quantities of components- such as chromium and manganese- which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume. Consult with us for specific compatibility information.

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### CLASSIFICATION

DIN 8555  
MF 6-GF-60-GP

### COMPATIBILITY

Clif-Clad® Overlay Steel Plate

### APPLICATIONS

Bucket Teeth  
Lips & Undersides  
Cutting Edges  
Cable Drums  
Dragline Buckets  
Conveyor Chutes  
Grizzly Bars  
Steel Mill Rolls  
Sand Dredge Equipment

