



# TENSAWELD ULTRA-200 HARDFACING

## DESIGNED FOR HIGH ABRASION

### DESCRIPTION

- Tubular hardsurfacing wire for open arc welding
- Chrome free for extra safety to welders
- Deposit contains boron carbides which allow strong abrasion resistance for earth moving application combined with moderate impact resistance
- Recommended for single layer application
- Hardness- 2-layer deposit on mild steel: 62 HRc
- Welding positions: Flat, half up, half down
- 100% compatibility with Tensalloy™ products

### CONDITIONS OF USE

Current Type	Protection*
DC (+)	Self Shielded

### PACKAGING

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

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

C	0.4
Mn	0.6
Ni	2
Si	1
Fe	Balance
Structure: Boron carbides in a martensitic matrix	

### 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	175	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.

**1.800.745.3962 | WWW.CLIFTONSTEEL.COM**

16500 ROCKSIDE ROAD  
MAPLE HEIGHTS, OH 44137

E-MAIL: INFO@CLIFTONSTEEL.COM  
FAX: 216.662.6107

### CLASSIFICATION

DIN 8555  
MF 6-GF-60-GP

### COMPATIBILITY

Clif-Clad® Overlay Steel Plate

### APPLICATIONS

Mixer Shafts  
Impellers  
Buckets  
Shovels  
Transport Screws  
Crushers

