



TENSAWELD ULTRA-300 HARDFACING

CREATED FOR SEVERE ABRASION

DESCRIPTION

- Tubular **hardsurfacing** wire for open arc welding
- The deposit contains multiple carbides in a tough iron matrix
- Designed for extreme abrasion, high stress grinding applications
- Hardness: 1-2 layer deposit on mild steel: 58-62 HRC
- Recommended for single layer application
- Welding positions: Flat, half up, half down
- 100% compatibility with Tensalloy™ products

TYPICAL WELD DEPOSIT CHEMISTRY (CO₂)

C	4-8
Mn	0.5-1
Si	0-1
Cr	5-8
V	4-7
Nb	2-5
W	1-3
Fe	Bal
Structure: multiple carbides in an abrasion resistant matrix	

CONDITIONS OF USE

Current Type	Protection*
DC (+)	Shelf Shielded

PACKAGING

Diameter	Standard	Weight
0.45"	Spool EN759 : BS 300	33 lb spool
1/16"		

RECOMMENDED WELDING PARAMETERS

Diameter		Amperage (A)		Voltage		Stick-Out (in.)		Recovery
mm	in.	Range	Optimum	Range	Optimum	Range	Optimum	
1.2	0.045	90-320	175	15-30	28	0.75-1.25	0.75	90%

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is their responsibility to assess its suitability for the intended application. Consult with us for specific compatibility information.

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CLASSIFICATION

DIN 8555

COMPATIBILITY

Clif-Clad® Overlay Steel Plate

APPLICATIONS

Asphalt Screws
Blast Furnace Charging
Equipment
Sinter Plant Parts
Ash Fans
Cement Mill Parts
Agricultural Implements
Mixer Paddles

