



MASTERWELD

MW1230

Tubular Tungsten Carbide

INTERNATIONAL CLASSIFICATIONS

DIN 8555: E21-UM-65-G
EN 14700 EFe20

FEATURES & APPLICATIONS

Ideally suited for overlaying mining and earth moving equipment. Excellent for wire saws and other edges requiring cutting action combined with abrasion resistance.

Tungsten carbide overlay within a high carbon steel matrix

- Specially selected carbides for maximum cutting action.
- Extremely high percent of tungsten carbide.
- Primary carbides provide maximum cutting action, while secondary carbides dissolve to strengthen matrix.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Carcoal Grey

| WC | Mn | Fe |
|----|-----|-----|
| 60 | 1.0 | bal |

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Carbide Hardness

Matrix Hardness

Coverage Approx.

Deposition Efficiency

Maximum Value Up to:

VPN 1200

RC 65-69

30 sq inches (1/16 thick)

Greater than 90%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC either polarity or AC

| Diameter (mm) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|------------------|------------|------------|------------|
| Minimum Amperage | 70 | 100 | 150 |
| Maximum Amperage | 120 | 170 | 210 |

Welding Techniques: Clean surface and remove old overlays and loosely adhering metal. Establish the arc holding the electrode near perpendicular and move quickly in the direction of travel. Use the stringer bead technique only - do not weave. Pull electrode out of final crater - do not back-whip. Normally a second pass will not be required. Deposits made this way will provide trapped projecting carbides for maximum cutting action.