

# PROLONG AR-B

Prolong AR-B is an enriched austenitic chromium carbide steel which readily relieves checks. Along with having moderate impact strength, it also retains excellent abrasion resistance to both coarse and/or fine particles. With a deposit that is grindable only, it is resistant to heat, corrosion, and high velocity erosion.

## APPLICATION

Prolong AR-B is used for as a hardfacing application on mild steel, low alloy steel and manganese steel. It is an excellent final overlay to use over most types of rebuilding wires. Prolong AR-B is also used in several typical applications such as cone crushers, crusher parts, digger teeth, catalyst piping, tool joints, crusher hammers, ore chutes, bucket lips, etc.

## SPECIFICATION

### TYPICAL MECHANICAL PROPERTIES

58 - 62 RC as deposited

### RECOMMENDED WELDING PARAMETERS

<b>Voltage</b>	26 - 30 for .045"
	26 - 30 for .062"
<b>Amperage</b>	120 - 160 for .045"
	210 - 275 for .062"
<b>Optimum</b>	28 - 150 for .045"
	28 - 230 for .062"
<b>Stick-Out</b>	1" - 2" for .045"
	1.5" - 2.5" for .062"

DC REVERSED POLARITY

REMOVE ALL DAMAGED MATERIAL

AVOID LOCALIZED OVERHEATING OF MANGANESE STEEL BY KEEPING BULK BELOW 550F

AVOID THERMAL SHOCK



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