

# PROLONG AR-T

Prolong AR-T is a metal cored, triple deoxidized Iron based wire, alloyed with Chromium and Tungsten. Unlike soft mild steel welding wires, which are commonly used in the embedding process, the microstructure of AR-T is designed to encapsulate and protect the Tungsten Carbide particles from premature erosion. Many of the common embedding wires are solid which require high voltage and amperage setting to achieve a fluid puddle. Prolong AR-T is metal cored and develops a spray transfer at very low current levels.

## APPLICATION

This product is primarily used as a matrix alloy for the Tungsten Carbide embedding process. Due to its unique properties make it an ideal choice when used with the Tungsten Carbide embedding process.

## SPECIFICATION

### RECOMMENDED WELDING PARAMETERS

<b>Polarity</b>	DC Reverse
<b>Gas Shielding</b>	98% Argon/2% Oxygen
<b>Flow</b>	35 CFH
<b>Stick-Out</b>	1 to 1.25"
<b>Preheat</b>	450/550F
<b>Hardness</b>	55 to 60Rc
<b>Wire Speed</b>	180 to 210 for .045" (1.14mm) 160 to 190 for 1/16" (1.6mm)
<b>Voltage</b>	26 to 28 for .045" (1.14mm) 27 to 29 for 1/16" (1.6mm)
<b>Amperage</b>	170 to 220 for .045" (1.14mm) 180 to 250 for 1/16" (1.6mm)

DEPOSITS ARE SLAG FREE

## PACKAGING

Available in 25 and 50 lb. spools.



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