

PROLONG AR-X

Prolong AR-X is a low alloy martensitic steel that offers good abrasion resistance and moderate impact capacity. While ideal for multiple layer hardfacing, the AR-X is not recommended in very high impact applications. The deposit resists relief checking and is also grindable. Prolong AR-X can be used as a final layer over a variety of rebuilding wires.

APPLICATION

Prolong AR-X is used for grouser plates, dozer blades, dredge buckets, cutter heads, mixer paddles, road graders, grouser plates, conveyor screws, cone crusher liners, etc.

SPECIFICATION

TYPICAL MECHANICAL PROPERTIES

42 - 48 RC as deposited
Work hardens to 50 - 55 RC

RECOMMENDED WELDING PARAMETERS

Voltage	24 - 28 for .045"
	26 - 30 for .062"
	28 - 34 for Large
Amperage	100 - 160 for .045"
	210 - 275 for .062"
	250 - 400 for Large
Optimum	26 - 140 for .045"
	28 - 230 for .062"
	32 - 350 for Large
Stick-Out	1" - 2" for .045"
	1.5" - 2.5" for .062"
	2" - 3" for Large

DC REVERSED POLARITY
REMOVE ALL DAMAGED MATERIAL
AVOID LOCALIZED OVERHEATING OF MANGANESE STEEL
AVOID THERMAL SHOCK

PACKAGING

Available in 28 and 10 lb. spools, 55 lbs. coils, 100, 250 & 500 lbs. pay-off-packs



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