

Overlay
Mild and Low Alloy Steels

FabTuf[®] 960

DESCRIPTION:

FabTuf 960 is a tubular, metal-cored wire that is designed for overlay applications, providing moderate impact strength and excellent metal-to-metal wear resistance.

APPLICATIONS:

Ore drag lines, dredge parts, muller tires, extruder worms, conveyor bucket lips coal conveyors, dragline chain, coupling boxes, mill guides, kiln trunnions, spindles and wobbler ends.

FEATURES:

- Good out-of-position welding capability
- High quality, uniform deposit
- Metal-cored product
- Lower fumes than conventional flux-cored wires

BENEFITS:

- Provides increased flexibility in joint positions
- Promotes porosity-free welds
- Offer high deposition efficiency with minimal or no slag
- Allows for better shop environment

TYPICAL WELD METAL PROPERTIES* (Chem Pad):

Weld Metal Analysis	CO ₂
Carbon (C)	0.70
Manganese (Mn)	2.00
Chromium (Cr)	8.00

MACHINABILITY: Possible by grinding
FLAME CUT: No
HARDNESS: 55-60 Rc
MACHINABILITY: Possible by grinding
WEAR INDEX: 35
TYPE OF CURRENT: DCEP
SHIELDING GAS: 100% CO₂ or 75% Ar/25% CO₂

RECOMMENDED WELDING POSITIONS:

Flat, Horizontal and Vertical

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Amps	Volts
Inches	(mm)			
.045	1.1	DCEP	120-210	20-28
1/16	1.6	DCEP	170-310	20-28

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