

## WELDING TECHNIQUES AND PROCEDURES

In all cases, minimum dilution processes are recommended to obtain maximum wear resistance.

OAW (Oxyacetylene) - Use a slightly carburizing flame (2-3 x feather), preheat base metal to a "sweat."

VERSAlloy® rods will then flow freely when introduced into the torch flame.

GTAW (Tig) - Use DC electrode negative (straight polarity) with largest size Tungsten electrode possible to minimize tungsten contamination of the weld puddle.

SMA (Coated Electrodes) - For faster deposition and fieldwork, electrodes are preferred. They can run either AC or DC. DC reverse polarity is recommended.

## PRODUCTS AND TYPICAL APPLICATIONS

ALLOY	HARDNESS	CONDITIONS	APPLICATIONS
<b>DIAMOND CARBIDE™ 60</b>	60+ RC	Extreme abrasion Low impact Corrosion	Severe abrasion Moderate impact Corrosion
<b>DIAMOND CARBIDE™ 55</b>	55+ RC	Agricultural, drill bits, mining tools	Food processing screws, augers, pipe elbows
<b>DIAMOND CARBIDE™ 50</b>	50+ RC	Extreme abrasion Slight impact Corrosion	Severe abrasion Severe impact Corrosion
<b>DIAMOND CARBIDE™ 40</b>	40+ RC	Digging tools, bits, stabilizer bars, teeth, conveyer screws	Pulp chippers, debarkers, mill hammer