

DESCRIPTION

Bare Acetylene Tube Borium is an oxy-fuel rod intended for metal-to-earth applications involving extreme abrasion and low impact. It is manufactured by metering crushed tungsten carbide particles of controlled mesh size into steel tubes. Borium is available in a variety of particle sizes – fine mesh sizes increase wear resistance and coarse sizes improve cutting efficiency.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Low
Cutting Efficiency	Excellent
Hardness of Borium Particles	9.9 on Moh's Scale
Magnetic	Yes
Deposit Layers	1
Surface Cross Check	No
Machinability	No
Hot Wear Applications	Up to 900 ⁰ F

ALLOY TYPE

Tungsten Carbide Particles in an Iron Based Matrix

TYPICAL APPLICATIONS

Typical applications include:

- Plow shares
- Cane knives
- Teeth
- Tool drill bits
- Helicopter pads

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	7/64 (2.8)	1/8 (3.2)
Mesh	30 – 40	20 – 30
Flame	3X	3X
Tip Size	4	4
Position	Flat	Flat
Length, in. (mm)	28 (710)	14 (355)

Diameter, in. (mm)	5/32 (4.0)	3/16 (4.8)
Mesh	20 – 30	20 – 30
	30 – 40	30 – 40
	30 Down	30 Down
Flame	3X	3X
Tip Size	4	5
Position	Flat	Flat
Length, in. (mm)	14 (355)	14 (355)
	28 (710)	28 (710)

STANDARD SIZES & PACKAGING

Diameter	Mesh Size	Packaging	Part #
7/64" x 28"	30 - 40	60# Box	11895000
1/8" x 14"	30 - 40	10# Box	10227100
5/32" x 14"	20 – 30	10# Box	10227500
5/32" x 28"	30 Down	60# Box	10230500
5/32" x 28"	30 – 40	10# Box	11429000
3/16" x 14"	20 – 30	10# Box	10227900
3/16" x 28"	30 Down	60# Box	10230700
3/16" x 28"	30 – 40	10# Box	10228100