

**DESCRIPTION**

The deposit is of modified H-12 tool steel composition. Its high hardness level provides excellent abrasion resistance and will withstand high compressive loading and softening at elevated temperatures. The deposit can be applied crack free when proper welding procedures are followed. The deposit is difficult to flame cut and can be machined using carbide tools. This alloy is not recommended where resistance to fire-cracking is required.

**TYPICAL DEPOSIT CHARACTERISTICS**

Thermal Fatigue Resistance	Poor
Abrasion Resistance	Excellent
Impact Resistance	Good
Compressive Strength	High
Hardness HRC	51
Machinability w/carbide tools	Difficult

**ALLOY TYPE**

Modified H-12 Tool Steel

**TYPICAL APPLICATIONS**

Typical applications include:

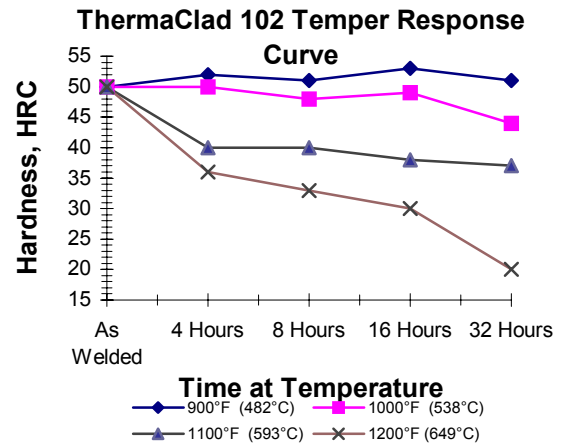
- Work rolls
- Leveler rolls
- Vertical edger rolls
- Dredge ladder rolls
- Flaking rolls
- Hot work extrusion rolls
- Bell seats
- Tool steel crane wheels

When crack-free deposits with high hardness at elevated temperatures are required ThermaClad 102 is the recommended overlay material. It exhibits good metal-to-metal and abrasion resistance.

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (in Stoodly R-20 Flux)**

SAW			
Diameter, In. (mm)	3/32 (2.4)	1/8 (3.2)	5/32 (4.0)
Current, Amp. DC+	300-400	400-500	450-600
Voltage	26 - 28	27 - 30	29 - 32
Wire Extension	1" - 1¼"	1¼" - 1½"	1¼" - 1½"

**HEAT TREATMENT DATA**



**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
1/8" (3.2mm)	100# Coil	11826000
1/8" (3.2mm)	500# POP	11820400
5/32" (4.0mm)	100# Coil	11827300
5/32" (4.0mm)	500# POP	11812100
3/32" (2.4mm)	100# Coil	11871600
3/32" (2.4mm)	500# POP	11905700

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