

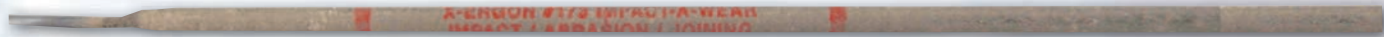


Impact-A-Wear™ SD

Multi-Purpose High-Deposition Alloy for Joining, Buildup and Overlay

Impact-A-Wear SD is a versatile electrode designed to be wear-resistant and is great for joining Wear-X™ hardfacing plates to base metal.

- Work-hardens during use — gets more abrasion-resistant with wear
- Impact-resistant — designed for high-impact applications
- Economical — SD coating provides superior deposition rate and excellent efficiency
- Excellent for joining dissimilar steels
- For use on carbon and alloyed abrasion resistant steels including manganese steels
- Cavitation and corrosion resistant
- Designed for flat and horizontal fillets



SPECIFICATIONS

Tensile strength.....	120,000 psi/827 MPa
Yield strength.....	72,000 psi/496 MPa
Hardness	
-work hardened	up to 50 Rc
-as deposited	90 Rb
Corrosion resistance.....	Very good
Crack resistance.....	Excellent
Impact strength.....	Excellent
Chemical resistance.....	Excellent
Heat resistance	Good, 500°F
Max number of passes	Unlimited
Current.....	DC or AC



PROCEDURE

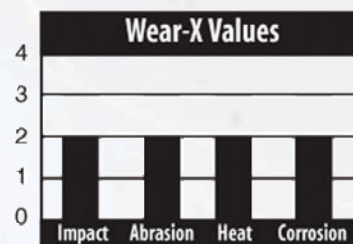
Remove defective metal and old hardfacing by gouging or grinding. Remove surface contaminants. Most applications don't require preheat except extremely hard steel and very thick sections. Use short arc length and stringer beads or narrow weave technique. Do not preheat manganese steel and use minimum heat input.



APPLICATIONS

- Attaching manganese ripper teeth
- Repairing cavitated pump housings
- Build-up worn impellers
- Attaching wearplate
- Use as a buttering pass between incompatible alloys

Code #	Diameter	Amperage
173-2-0000	3/16"	165-270
173-3-0000	5/32"	120-210
173-4-0000	1/8"	90-150



DOD EMALL
<https://dod.emall.dia.mil>
 SP47W1-17-D-0009
 Available in select sizes only