



# HI-ALLOY 101

## TUNGSTEN CARBIDE TUBE METAL

Hi-Alloy 101 is produced as a mild steel tube filled with crushed and sized granules of tungsten carbide. The deposited metal is typically 60% carbide and 40% tube by weight. The deposited material is surprisingly tough, very abrasion resistant, and will withstand moderate impact. A number of different granule (mesh) sizes are available to suit most any requirement. The standard granule size is 30-40 but below is a list of other sizes available by special request. Some restrictions may apply.

8 -10 Horseshoe rod ¼" only

14 - 24  
20 - 30  
40 - 60  
60 - 100  
80 - 200

### Application Data

**Bare Rod:** Adjust torch to an excess acetylene flame, 3X of inner cone. Use a tip one size larger than normally used to weld the same diameter mild steel rod. Sweat the deposit to the base metal with minimum penetration. Avoid puddling.

**Coated Rod:** Use minimum amperage; consistent with good penetration. May be applied using AC or DC Reverse polarity. Apply in flat or slightly inclined position.

Rod Diameter	Amperage
1/8	80 - 100
5/32	100 - 120
3/16	120 - 150
1/4	150 - 175