HI-ALLOY AM354

BUILD-UP ALLOY RESISTS EXTREME IMPACT

DESCRIPTION: Hi-Alloy AM354 was designed to be used as a build-up alloy capable of resisting extreme impact and compressive wear on both carbon and austenitic manganese steels. It may also be used for joining carbon steel and mild steel to manganese steel with high tensile strength. Welds are flame cuttable, crack resistant, dense, and porosity free.

TYPICAL APPLICATIONS: Hammermill hammers, rock crusher mantles and rolls, impactor bars, swing hammers, railroad frogs, railroad crossovers, rail ends, and various quarry and stone crushing operations.

PROCEDURES: Clean the base metal and remove all prior deposits of hardfacing material. Do not preheat manganese steels, select lower amperage range to minimize heat input. Interpass temperature should not exceed 500° F, maintain a short arc length, use skip weld technique with about 4" beads, peen the beads to distribute stresses, allow the finished part to cool slowly in still air.

AVAILABLE SIZES:	1/8	5/32	3/16
AMPERAGE RANGES:	85 - 125	110 - 140	130 - 170
POLARITY:	AC or DC Reverse		
TENSILE STRENGTH:	Up to 125,000 psi		
HARDNESS:	As Welded Rockwell C 35 - 38 Work Hardens Up To Rockwell C 50		