

# ARCTEC® 677 TUNGSTEN



## GENERAL CHARACTERISTICS:

ARCTEC® 677 TUNGSTEN is a composite tungsten carbide electrode for use with oxy-acetylene welding. The deposit achieves a very high degree of wear resistance. Exhibits moderate stress relief checking. Machineable by grinding only.

## APPLICATIONS:

ARCTEC® 677 TUNGSTEN is particularly suited for hardfacing of oilfield drill bits, drill stems, augers, asphalt plant mixer blades and other applications subject to severe abrasion and moderate impact.

## WELDING PROCEDURE:

Clean the weld zone of oil, grease, rust and other contaminants by grinding if necessary. Apply with oxy-acetylene torch using a slightly carburizing flame. Allow the weld deposit and surrounding area to cool slowly. Deposit should be limited to two (2) layers.

## MECHANICAL PROPERTIES:

	Hardness
Matrix:	55-60 RC
Carbide:	70-74 RC

**Note:** Hardness of Tungsten Carbide is difficult to measure, but for the purpose of relating to a known quantity we have chosen to show it as 70-74 RC.

## OPERATING PARAMETERS:

WELDING PROCESS: OFW

Diameter	4.0mm 5/32"	5.0mm 3/16"
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