



EVERWEAR 800 ELECTRODE

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION;

Everwear 800 is a hardsurfacing electrode used for severe abrasion, light/moderate impact and corrosion resistance. This electrode produces an extremely hard martensite-structure weld deposit which is not machinable in the “as- welded” condition. Everwear 800 is commonly used on mill hammers, bucket teeth/blades/lips, cement mixers, conveyor screws/augers, valve seats, mixers, ore chutes, crusher rolls/hammers, tamper rollers and other mild steel, carbon or alloy steels as well as manganese steels.

TYPICAL WELDING PROCEDURES; RECOMMENDED AMPERAGE (AC OR DC+)

Diameter	Amps (Flat)	Volts
1/8”	90-130	24-28
5/32”	140-180	25-31
3/16”	180-240	25-32

PROCEDURES Use AC or DC+. **CLEAN WLED AREA THOROUGHLY.** Preheating is not required except on alloy steels and helpful in general 400°F. Using a short gap with a slight weaving technique or stringer beads, deposit of two layers. If more than two passes are required, use Tensileweld or Buildup 300 to provide a padding layer prior to using Everwear 800.

CHARACTERISTICS Everwear 800 will lay down a smooth, corrosion resistant weld deposit which will remain extremely hard even at elevated temperatures. Hardness as deposited: RC62-65.

Procedures are base on flat position and may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY AND PROPERTIES;

Carbon	0.71	Manganese	1.54
Silicon	1.60	Phosphorus	0.018
Sulphur	0.007	Molybdenum	0.15
Chromium	5.25		

Hardness Rockwell C = 58-65

AVAILABLE SIZES: TH 800 1/8, 5/32, 3/16

Other sizes available – please inquire

SPECIFICATIONS; **Internal ;** JIS Z 3251-2000, DF3C-700-B ; KS DF3C-700-B

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