



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# 600HT Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.  
dba Washington Alloy  
825 Groves Street  
Lowell, NC 28098  
[www.weldingwire.com](http://www.weldingwire.com)



### ALLOY DESCRIPTION AND APPLICATION:

Washington Alloy 600 HT (Hardfacing- Heavy Abrasion, Heavy Impact and Corrosion Resistant) offers high abrasion and heavy impact resistance on carbon, low alloy, and manganese steel. Weld deposits are martensitic and corrosion resistant. 600 HT is designed for metal to metal and metal to earth abrasion. Weld deposits will work harden when put to service. Typical applications would include tillage tools, bucket lips, extruder screws, tamper feet, dredge parts, cutter teeth, Ore Drag Lines, Muller Tires and wherever high abrasion and heavy pounding is encountered. Forgeable but not readily machinable and desirable choice for sharp edge.

IMPACT RESISTANCE ; Excellent      ABRASION RESISTANCE ; Excellent  
COMPRESSION ; Good- Excellent

### TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO <sub>2</sub> (cfh)
0.045	195- <b>300</b> -475	125- <b>205</b> -265	20- <b>24</b> -28	1/2-1"	35-45
0.052	150- <b>270</b> -320	140- <b>255</b> -320	22- <b>25</b> -29	1/2-1"	40-50
1/16"	135- <b>240</b> -240	250- <b>310</b> -350	23- <b>25</b> -29	3/4-1.75"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment, and other changes.  
1-2 VOLTS LOWER USED WITH MIXED GAS

### TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

Carbon	0.438	Chromium	6.98
Manganese	0.48	Iron	Balance
Silicon	2.28	Molybdenum	0.51
Phosphorus	0.019	Vanadium	0.04
Sulfur	0.007	Tungsten	0.001
Hardness    Rockwell C = 53-58			



**AVAILABLE SIZES:** THF 600HT= Spools of .045, 1/16"

Other sizes available – please inquire



10-22 DC

### SPECIFICATIONS; Internal , JIS Z 3326-2007 YF3B-C-600

<b>EAST COAST</b> 825 Groves Street Lowell, NC 28098 Tel (980) 550-2002 Fax (909) 291-4586	<b>GULF COAST</b> 11723 Cutton Road Houston, TX 77066 Tel (888) 552-8296 Fax (909) 291-4586	<b>WEST COAST</b> 8885 White Oak Ste. 104 Rancho Cucamonga, CA 91730 Tel (888) 522-8296 Fax (909) 291-4586	<b>NORTHEAST COAST</b> 101 Wales Avenue Avon, MA 02322 Tel (888) 552-8296 Fax (909) 291-4586
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Warehouse Distribution Center – Ridgefield, WA

Head Office – Lowell, NC

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