



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

700HT Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

700HT offers a harder weld deposit than USA 600 HT with lower corrosion resistance. Primarily used for high metal to metal abrasion. Weld deposits are martensitic in structure and will work harden when put into service. Bonds well with fatigued or older hard-faced deposits and preheat/interpass of 300-500°F may yield superior properties. Typical applications would include the hard surfacing of rollers, conveyor screws, crusher rolls and mill hammers.

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

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.045	195- 300 -475	125- 205 -245	25- 27 -29	1/2-1"	35-45
0.052	150- 270 -320	140- 275 -290	24- 26 -30	1/2-1"	40-50
1/16"	135- 240 -240	150- 330 -305	23- 25 -31	3/4-1.25"	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	0.40	Chromium	6.20
Manganese	0.520	Vanadium	0.18
Silicon	2.25	Molybdenum	0.72
Phosphorus	0.017	Tungsten	0.64
Sulfur	0.011	Nickel	0.50
Hardness		Rockwell C = 58-61	

AVAILABLE SIZES: THF 700HT= Spools of .045, 1/16"

SPECIFICATIONS; Internal ; JIS Z 3326-2007, YF3B-C-700

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