



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

# Chrome-Carb 60 ELECTRODE

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



### ALLOY DESCRIPTION AND APPLICATION;

Chrome-Carb 60 is a high chrome-high carbon electrode that yields deposits that are extremely tough, giving the maximum protection against moderate impact and severe abrasion on the initial deposit. Its deposit is composed of primary chromium carbides in a semi-austenitic matrix which is non-machinable and may stress relief crack check. While one to two pass are recommended multiple layers can be performed in certain tested applications. With its high compression strength and protection at service temperatures up to 1100°F it yields uncompromised service. Pre-heating is not a required need but shall be warmed up in cold environments. However, heavy sections or high carbon base metals may require preheat for optimum results.

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

Diameter	Amps (Flat)	Volts	Diameter	Amps (Flat)	Volts
3/32"	85-130	25-34	5/32"	135-200	25-31
1/8"	110-150	24-28	3/16"	195-210	25-32

Voltage is estimate and will vary

**PROCEDURES** Use AC or DC+. Preheating is generally not required. Using the weaving technique and keeping a short arc length, deposit up to 1/4" maximum. If more than two passes will be required, it is suggested that a "padding layer" of Buildup 300 or Tensileweld be used prior to depositing Hardface.

**CHARACTERISTICS** When used in the flat and horizontal positions, this electrode will exhibit a stable arc and produce weld deposits that are smooth and rippled. Hardness as deposited: RC58-62

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

### TYPICAL CHEMISTRY AND PROPERTIES;

Carbon	3.09	Manganese	0.68
Silicon	0.89	Phosphorus	0.015
Sulphur	0.017	Molybdenum	0.04
Chromium	32.15		

Hardness Rockwell C = 58-62

**AVAILABLE SIZES:** TH 60 3/32, 1/8, 5/32, 3/16

Other sizes available – please inquire



### SPECIFICATIONS; Internal

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