

# Prime-Arc 22

**Prime-Arc 22 JW** Joining Wire

**Prime-Arc 22 JE** Joining Electrode

Prime-Arc 22 JW and Prime-Arc 22 JE welding consumables are specifically designed for joining and build-up repair of worn manganese steel.

These consumables deposit a soft, austenitic manganese overlay that work hardens to 650+ BHN under impact loading. These alloys perform best in applications where a combination of wear and severe impact loading is present.

Deposits can be flame cut, and there is no limit to the overlay application thickness.

## Applications

Prime-Arc 22, is designed for maximum performance in extreme impact environments. It excels in hammer mills, crusher rolls, impact plates, frogs and switches, and other similar environments.

## Benefits

Under Impact loading, the soft austenitic material (220 BHN), transforms to Martensite at 600+ BHN. The transformation leaves an ultra-hard surface that resists wear, while maintaining a soft and ductile base to absorb further impact. As the surface wears, another layer is produced, resulting in a surface with self-healing properties under the load.

## Technical

Deposits will not check crack, and the flux material gives a smooth running wire with little spatter and an easily removable slag. Can be applied to carbon and manganese steels. Can be applied in multiple layers without cracking. After build up, a surface of Prime-Arc 300 or Wear arc 400™ can be applied for initial wear resistance.

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