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.